



# Selectarc Inox 253MA-AC

High Temperature  
Stainless Steel Electrode

## Classification

ISO 3581-A : E 22 12 R 3 2

EN 1600 E 22 12 R 3 2

## Description & Applications

Rutile coated electrode with an austenitic stainless steel deposit resisting to scaling and oxidation up to 1100°C. Regular and stable fusion, good slag removal, nice aspect of the bead.

**Main applications:** Ovens, thermal equipments for heat treatment, chemical installations.

### Base materials

| UNS    | Alloy | EN 10095           | Material N° | UGINE         |
|--------|-------|--------------------|-------------|---------------|
|        |       | X15CrNiSi20-12     | 1.4828      | UGINOX R20-12 |
|        |       | X12CrNi22-12       | 1.4829      |               |
| S30815 | 253MA | X8CrNiSiN21-11     | 1.4893      |               |
|        |       | X9CrNiSiNCe21-11-2 | 1.4835      |               |

## Typical Weld Metal Composition ( % )

| C   | Si  | Mn  | Cr   | Ni   | N   | Mo  | Fe   |
|-----|-----|-----|------|------|-----|-----|------|
| 0.1 | 1.0 | 0.8 | 22.0 | 11.0 | 0.1 | 0.1 | Rem. |

## All Weld Metal Mechanical Properties

| $R_{p0.2}$ ( MPa ) | $R_m$ ( MPa ) | $A_5$ ( % ) |
|--------------------|---------------|-------------|
| >350               | >550          | >25         |

## Welding Current & Instructions

| Electrode | ØxL ( mm ) | 2,5x300 | 3,2x350 | 4,0x350 |
|-----------|------------|---------|---------|---------|
| Current   | ( A )      | 70      | 100     | 130     |

Redrying 2 hours at 250°C, if necessary. Interpass temperature: < 150°C.

Ind.12



= + ~ 70 V

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