



MIG 20/10MA

Old reference: MIG 253MA

Classification

ISO14343-A : G Z 21 10 N H Material N° : ~1.4835

Description & Applications

Solid wire electrode for Gas Metal Arc Welding with an austenitic stainless steel deposit resisting to scaling and oxidation up to 1100°C.

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

Base materials

UNS	Alloy	EN 10095	Material N°	UGINE
		X15CrNiSi20-12	1.4828	UGINOX R 20-12
		X12CrNi22-12	1.4829	
S30815	253MA	X8CrNiSiN21-11	1.4893	
		X9CrNiSiNCe21-11-2	1.4835	

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	N	P	S	Fe	FN
0.08	1.5	0.5	21.0	10.0	0.15	<0.02	<0.01	Rem.	~5

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
440	670	38	20°C 120

Welding Current & Instructions

Welding mode	Ø wire (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	100-150	22-27	Ar + 30% He + 2%CO ₂ Ar + 2%CO ₂ Ar + 1%O ₂ 16-18 l/min
	1.0	120-200	24-28	
	1.2	140-220	24-28	

Ind.12



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