



## SELECTARC TIG 21/10MA

Old reference : TIG 253MA

### Classification

ISO 14343-A : W 21 10 NH

Material N<sup>o</sup>

: ~ 1.4835

### Characteristics

Rod for Gas Tungsten Arc Welding with an austenitic stainless steel deposit resisting to scaling and oxidation upto 1100°C.

### Applications

Ovens, Thermal equipments for heat treatment, Chemical installations.

#### Base materials

UNS	ALLOY	EN 10088	Material N <sup>o</sup>	UGINE
		X15CrNiSi20-12	1.4828	UGINOX R 20-12
S30815	253MA	X12CrNi22-12	1.4829	
		X8CrNiSiN21-11	1.4893	
		X8CrNiSiN21-11-2	1.4835	

### Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	N	P	S	Fe
0.08	1.50	0.50	21.00	10.00	0.15	0.015	0.007	base

### All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R <sub>m</sub> (MPa)	YS R <sub>p0.2</sub> (MPa)	% Elg A <sub>5</sub>	Impact (KV) Temp. °C	J	FN (WRC)
AW	650	450	38	+ 20	120	3

### Welding Current & Instructions

Welding Mode	Shielding Gas
TIG = -	Ar : 6 - 12 l/min Back Shielding : Ar / N <sub>2</sub> / H <sub>2</sub> : 5 - 6 l/min

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