



# 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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