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Inox 253MA

High Temperature Stainless Steel Electrode

FSH WELDING GROUP
INNOVATIVE WELDING CONSUMABLES
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Classification

ISO 3581-A : E 22 12 B 42 EN 1600 : E 22 12 B 42

Description & Applications

Basic coated electrode with an austenitic stainless steel deposit resisting to scaling and oxidation up to 1100℃. 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 R 20-12
		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	Fe
0.1	1	1.5	22.0	11.0	0.1	Rem.

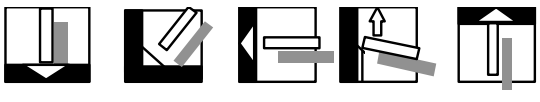
All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
380	550	35

Welding Current & Instructions

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

Redrying 2h at 250℃, if necessary. Interpass temperature: <150℃.



1G/PA 2F/PB 2G/PC 3G/PF 4G/PE

= +

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