

IABCO ER253MA

Wire for high temperature stainless steel

Product name	IABCO ER253MA		
Classification EN ISO	14343-A: ~ W/G 21 10 N		
Material No.	-		
Classification AWS	-		
Approvals	-		
Applications	For welding matching base materials; the welding wire having a controlled ferrite content to ensure good hot cracking resistance. The material exhibits good creep strength. The material also exhibits good sulphidation and oxidation resistance up to ~1150°C. Typical applications include furnace equipment, high temperature flue systems, exhausts.		
Base materials	For high temperature matching stainless steels. ASTM: S30815. EN: 1.4828, 1.4835, 1.4893. Proprietary: 253MA (Outokumpu).		
Typical analysis of wire, weight %	C: 0.08 Mn: 0.5 Ni: 10 Ce: 0.06	Si: 1.6 Cr: 21 N: 0.17	
Typical heat treatment ⁽¹⁾	Preheat: Not required. Interpass temperature: Recommended 150°C maximum. PWHT: Not normally required.		
Typical mechanical properties of weld deposit ⁽²⁾	0.2% proof stress, Rp0.2%: 360MPa. Tensile strength, Rm: 580MPa. Elongation, 4d/5d: 40%. Impact ISO-V, +20°C: 120J.		
Other products	-		

Notes (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.