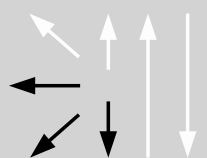


Classification							
Wire:					Flux:		
EN ISO 14343-A	EN ISO 14343-B	AWS A5.23		EN ISO 14174			
-	-	-		-			
Characteristics and typical fields of application							
Avesta 253 MA is designed for welding the high temperature steel Outokumpu 253 MA, used for example in furnaces, combustion chambers, burners etc. Both the steel and the consumable provide excellent properties at temperatures 850 – 1100 °C. The composition of the consumable is balanced to ensure a crack resistant weld metal.							
Structure: Austenite with 3 – 10 % ferrite.							
Scaling temperature: Approx. 1150 °C (air).							
Corrosion resistance:							
Excellence resistance to high temperature corrosion. Not intended for applications exposed to wet corrosion.							
Base materials							
Outokumpu	EN	ASTM	BS	NF	SS		
153 MA™	1.4818	S30415	-	-	2372		
253 MA®	1.4835	S30815	-	-	2368		
Typical analysis of the solid wire and all-weld metal (wt.-%)							
	C	Si	Mn	Cr	Ni	N	Ferrite
Wire	0.07	1.6	0.6	21.0	10.0	0.15	2 FN (WRC-92)
Flux 801	0.07	2.1	0.2	21.0	9.0		14 (DeLong)
Flux 805	0.07	1.8	0.2	21.5	9.0		15 (DeLong)
Mechanical properties of all-weld metal							
Flux	Yield strength R _{p0.2}	Tensile strength R _m		Elongation (L ₀ =5d ₀)		Impact work ISO-V KV J	
	MPa	MPa		%		+20 °C	–40 °C
Flux 801	470	690		39		90	-
Operating data							
	Polarity: DC (+) / DC (-)		Re-drying: 300 – 350 °C / min. 2 h			ø (mm) 2.4 3.2	
Preheating and Heat treatment are generally not necessary. Interpass temperature: Max. 150 °C. Heat input: max. 1.5 kJ/mm.							
Approvals							
-							