



CEWELD 4893 Kb (253MA)

TYPE Rutile coated electrode for heat resistant stainless steel SMAW welding.

APPLICATIONS Joining and cladding high heat resistant CrNi-steels of the same kind such as heat treatment equipment and chemical installations.

PROPERTIES High corrosion resistance and excellent weldability on both AC and DC+. The weld deposit is scale and oxidation resistant up to 950°C. Interpass temperature should be kept below 150°C.

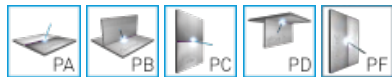
CLASSIFICATION

EN ISO	3581-A: E Z 23 10 N R 12
W.Nr.	1.4893
F-nr	5
FM	5

SUITABLE FOR 1.4828, 1.4829, 1.4893, 1.4835, 1.4818, 1.4825, 1.4826, 1.4832, 1.4891, 1.4893
X15CrNiSi 20-23, X12 CrNi 22-12, X8CrNiSiN21-11, X9CrNiSiNCe21-11-2
UNS S30815,
AISI 309
(Avesta) alloy 253MA

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	N
0.1	1	0.97	22	11	0.1	0.1

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	360	590	27	HRc

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175