

DIFFUSALLOY 253 MA

DIFFUSALLOY 253MA is high strength “ LO TEMP” austenitic stainless steel electrode that contain special micro alloying elements. These Special Micro alloying elements makes the weld deposit highly resistance to scaling and oxidation upto 950⁰C and provide superior service in Carbon, Nitrogen and Sulphur containing atmospheres. Welding of AISI grades 253MA, 310, etc can be done easily. Stable Fusion, Easy Slag removal and Smooth and Bright bead appearance.

Applications:

DIFFUSALLOY 253MA is used in Furnace components, Ovens, Petrochemical and Refinery tube hangers, In Power boilers etc.

Procedure:

Preheat electrode to 150⁰C to reduce moisture. Clean weld area and clamp long seams. Use back up plates to minimize distortion on thin sheets. Tack at short intervals. Use electrode on AC/DC + at the lowest amps. Maintain very short arc and chip slag between passes. Avoid weaving.

Major Alloying element:

C	Si	Cr	Ni	N
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Technical Data

Size (mm)	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	45 – 70	85 – 115	100 – 135	135 - 170
Tensile Strength	:	70 kgf / mm ² (Min.)			
Elongation	:	25% (Min.)			
CVN Impact Strength at 20 ⁰ C	:	50 J (Min.)			
Tip Colour	:	Yellow			

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