

Classifications

EN ISO 14343-A	AWS A5.9 / SFA-5.9
S 21 10 N	-

Characteristics and typical fields of application

Designed for welding the high temperature steel Outokumpu 253 MA, used for example in furnaces, combustion chambers, burners etc., and provides excellent properties at temperatures 850 – 1100°C. Scaling temperature: Approx. 1150°C (air). Excellence resistance to high temperature corrosion. Not intended for applications exposed to wet corrosion. Weld metal structure contains austenite with 3 – 10% ferrite. The weld metal has a tendency to give a thick oxide layer during welding and hot rolling. Black plates and previous weld beats should be carefully brushed or ground prior to welding.

Typical analysis of the wire

	C	Si	Mn	Cr	Ni	N
wt.-%	0.07	1.6	0.50	21.0	10.0	0.15

Typical fluxes to combine

Process	Name	EN ISO 14174
SAW	Marathon 805 (Avesta Flux 805)	S A AF 2 DC

Packaging

Size(s) in mm	Type	Weight
2,4	basket spool	25 kg

Other sizes and coil weights on request.

