



# 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<br>X15CrNiSi 20-23, X12 CrNi 22-12, X8CrNiSiN21-11, X9CrNiSiNce21-11-2<br>UNS S30815,<br>AISI 309<br>(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 <sub>P0.2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Hardness |
|----------------|----------------------------|-------------------------|-----------------------|----------|
| As Welded      | 360                        | 590                     | 27                    | HRc      |

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175