DIFFUSALOY 253 MA

DIFFUSALOY 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 950°C 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:

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

Procedure:

Preheat electrode to 150°C 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:

<table>
<thead>
<tr>
<th></th>
<th>C</th>
<th>Si</th>
<th>Cr</th>
<th>Ni</th>
<th>N</th>
<th></th>
</tr>
</thead>
</table>

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 / mm² (Min.)
Elongation : 25% (Min.)
CVN Impact Strength at 20°C : 50 J (Min.)
Tip Colour : Yellow