



# 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 <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	360	590	27	HRc

**REDRYING** 300°C / 2 hr

**GAS ACC. EN ISO 14175**