

# KT-253MA

## Classification

UNS S30815  
EN 1.4835

### Applications and Features

- ( 1 ) Weld metal is austenitic stainless with 0.2% nitrogen and 0.05% rare earth (Ce)
- ( 2 ) For welding matching composition high temperature plate, pipe and fittings.
- ( 3 ) It is has very good strength and oxidation resistance at high temperatures, upto 1100°C
- ( 4 ) As this material has a tendency to form thick oxide layer during welding or service, black plates and previous weld beads should be properly brushed or ground before welding.

### Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr	Ni	Ce	N
0.075	1.71	0.48	0.012	0.004	20.9	10.1	0.05	0.18

### Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2% O<sub>2</sub>)

Tensile Strength MPa	Yield Strength MPa	Elongation %
740	430	42

### Sizes and Suggested Operating Range

Size mm	Current A	Gas Flow L/min	Shielding Gas
16	75 - 100	25	Ar
24	150 - 200	25	Ar

Diam.	5 kg Tube
<b>1.6mm</b>	KT253MA16
<b>2.4mm</b>	KT253MA24

TALARC Pty Ltd  
10-16 Syme St  
Brunswick, Vic 3056  
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710  
W: [www.talarc.com](http://www.talarc.com) E: [sales@talarc.com](mailto:sales@talarc.com)