

# KM-253MA

## Classification

Shielding Gas:	Ar+1~2%O <sub>2</sub>	UNS S30815
	Ar+1~2%CO <sub>2</sub>	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 has very good strength and oxidation resistance at high temperatures, upto 1100°C

### Welding Instruction

- ( 1 ) Use Ar blend with 1~2%O<sub>2</sub> for high current, spray transfer welding .
- ( 2 ) Use Ar blend with 1~2%CO<sub>2</sub> for low current, short-circuit transfer welding.
- ( 3 ) 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

### Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm)	
		0.9	1.2
Ar+1~2%CO <sub>2</sub>	Amp	60~140	100~210
	Volt	15~21	17~22
Ar+1~2%O <sub>2</sub>	Amp	170~260	200~300
	Volt	24~30	24~30

Diam.	5 kg Spool	15 kg Spool
0.9mm	KM253MA0905	KM253MA0915
1.2mm		KM253MA1215

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