

Supermet® 253MA

TOP FEATURES

- All-positional stick electrode with an acid rutile flux system on alloyed core wire
- Controlled Si and rare earth (RE) additions (mainly cerium) provide excellent oxidation resistance.
- Recovery is about 115%

CLASSIFICATION

EN ISO 3581-A E Z 22 10 N R 3

CURRENT TYPE

DC+/AC

WELDING POSITIONS

All position, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	N	Cu	Ce*	FN
Min.	0.04	not specified	1.4	not specified	not specified	21.0	9.0	not specified	0.14	not specified	not specified	3
Max.	0.10	1.0	2.0	0.020	0.035	23.0	11.0	0.5	0.20	0.5	trace	10
Typical	0.06	0.8	1.5	0.010	0.020	22	10.3	0.1	0.16	0.1	0.05	5

*Cerium is present but actual value not reported on test certificate.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	As welded	Typical
Tensile strength	(MPa)	705
0.2% Proof strength	(MPa)	550
Elongation (%)	4d	40
	5d	38
Reduction of area (%)		50

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	50-75
3.2 x 350	75-120
4.0 x 350	100-155

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	VPMD	55	2.1	SM253MA-32-2
4.0 x 350	VPMD	37	2.1	SM253MA-40-2

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.