

## SUPERMET 253MA

MMA (SMAW)

## RUTILE MMA ELECTRODE FOR MATCHING ALLOY 253MA

## PRODUCT DESCRIPTION

All-positional MMA 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% with respect to core wire, 65% with respect to whole electrode.

## CLASSIFICATIONS

There are no applicable national standards

## ASME IX QUALIFICATION

QW432 F-No --  
QW442 A-No 8

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

## CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	N	Cu	Ce *	FN
Min.	0.04	--	1.4	--	--	21.0	9.0	--	0.14	--	--	3
Max.	0.10	1.0	2.0	0.020	0.035	23.0	11.0	0.50	0.20	0.50	trace	10
Typical	0.06	0.8	1.5	0.01	0.02	22	10.3	0.1	0.16	0.1	0.005	5

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

## ALL-WELD MECHANICAL PROPERTIES

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

## TYPICAL OPERATING PARAMETERS, DC +VE OR AC (OCV: 50V MIN)

Diameter (mm)	2.5	3.2	4.0
min. A	50	75	100
max. A	75	120	155

## PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				can	box	can	box
METAL CAN	2.5	300	SM253MA-25	CONSULT US			
	3.2	350	SM253MA-32				
	4.0	350	SM253MA-40				

Redrying : 200 – 300°C/1-2h to restore to as-packed condition. Maximum 400° C, 3 cycles, 10h total.

## FUME DATA (WT % TYPICAL)

Fe	Mn	Ni	Cr	Cu	F	OES (mg/m <sup>3</sup> )
9	6	1	7	<0.2	17	0.7

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to [www.specialalloys.eu](http://www.specialalloys.eu) for any updated information.