



# Cromarod 253

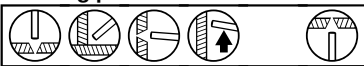
SMAW - (Stick) - MMA  
Stainless Steel

Date: 2009-02-27  
Revision: 16

### Description:

Cromarod 253 is a special rutile flux coated electrode designed for high temperature stainless steels of similar composition used at temperatures up to 1150 °C. The electrode is made on a fully alloyed core wire and deposits a 0.06%C / 22%Cr / 10.5%Ni / 0.17%N weld metal, microalloyed with the rare earth metal cerium to give stable high temperature mechanical and oxidation properties. Cromarod 253 runs with a low spatter arc to produce a smooth weld bead finish, easy slag detachability and particularly good vertical-up operability.

### Welding positions:



### Coating type:

Rutile

### Welding current:

DC +, AC 0CV > 39V

### Ferrite content:

FN 4 (WRC-92)

### Corrosion resistance

Designed for high temperature oxidation applications. Its resistance to wet corrosion is limited.

### Scaling temperature:

Approx. 1150 °C in air.

### Redrying temperature:

350 °C, 2h

### Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		1,2	0,4			21,5	9,5
Typical	0,06	1,5	0,5	0,02	0,005	22,0	10,5
Max	0,08	2,0	1,0	0,030	0,015	23,5	11,0

	Mo	Cu	V	Nb	N
Min					0,14
Typical					0,17
Max	0,3	0,3	0,1	0,1	0,20

### Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	540 MPa
Tensile Strength, Rm:	≥ 550 MPa	700 MPa
Elongation, A5	≥ 25	35%
Impact energy, CV:		20 °C • 55 J -60 °C • 38 J

### Classification:

### Approvals:

CE

### Note

Core wire:  
P ≤ 0.025%  
S ≤ 0.015%  
0.14% ≤ N ≤ 0.20%  
Ce ~0.05%

### Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	300	74552500	40-80	22	0,65	89	0,7	59
3,2	350	74553200	70-110	23	0,65	46	1,1	63
4,0	350	74554000	100-140	24	0,65	30	1,6	66