

Stick Electrode for Stainless Steel

KS-2553

Classification

AWS A 5.4	E2553-16
JIS Z3221	ES2253-16
EN 3581-A	—
GB T 983	E2553-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is 25%Cr-7.5%Ni-3.5%Mo-0.17%N.
- (2) It provides outstanding strength and excellent resistance to pitting and stress corrosion cracking.
- (3) It is suitable for welding 25%Cr duplex stainless steel, such as UNS S32550.

Welding Position

All Positions

Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For other instructions and information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni	Mo	N
0.050	0.90	0.80	0.015	0.020	24.71	7.92	3.31	2.23

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Ferrite Number
N/mm ² (kgf/mm ²)	N/mm ² (kgf/mm ²)	%	(FN)
900(91.0)	720(73.4)	22	45

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)		3.2x350	4.0x350
Amp	F/H-Fillet	80~120	100~150
	V-up/OH	70~110	90~135