

MIDALLOY MASTERCOR® E2553TO-4 FLUX-CORED WIRE

CLASSIFICATION

- AWS Class E2553TO-4 / ASME SFA 5.22 Class E2553TO-4

DESCRIPTION

- MIDALLOY MASTERCOR E2553TO-4 is a flux-cored stainless steel wire designed to run with 75% Ar-25% CO2 in the flat or horizontal position.
This wire has a smooth, globular transfer and easy slag removal.

APPLICATIONS

- MIDALLOY MASTERCOR E2553TO-4 is used for welding "super duplex" alloys with approximately 25% chrome to themselves and for overlay.
Applications requiring high strength and resistance to pitting and stress corrosion for use in marine, chemical and petroleum industries.

PROCEDURE

- No preheat. Maximum interpass temperature of 300° F.
Annealing may be required to achieve uniform hardness on multi-pass weldments.
Heat input should be limited to 5-40 KJ/IN.

TYPICAL MECHANICAL PROPERTIES

Table with 2 columns: Property Name and Value. Rows include HARDNESS (25 RC as welded, 35 RC work hardened), TENSILE STRENGTH (110,000 PSI Min.), and ELONGATION (15 % Min.).

WELDING PARAMETERS

Table with 6 columns: SIZE, VOLTS, TYPICAL AMPS, STICKOUT, POLARITY, GAS TYPE FLOW. Values include .045, 25-33, 150-300, 3/4" - 1", DCRP, and 75% Ar-25% CO2 30-40 SCFH.

STANDARD PACKAGING

- 33 lb. spool

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