

## MIDALLOY CHROMAX E2553-16 COATED ELECTRODE

### CLASSIFICATION

- AWS 5.4 CLASS E2553-16 /ASME SFA 5.4 E2553-16 (UNS W39553)

### DESCRIPTION

- Midalloy CHROMAX E2553-16 is a super duplex used for SMAW.

### APPLICATIONS

- Midalloy CHROMAX E2553-16 is utilized to weld super duplex stainless such as Ferralium 255™ (UNS32550), SAF 2507™ (UNS32750), DP-3™ (UNS31260) and other 25% chromium duplex stainless steels.
- Utilized for corrosion resistance overlays.

### TYPICAL CHEMICAL COMPOSITION

C	Mn	Si	Cr	Ni	Mo	P	S	N	Cu
.04	1.1	.65	25.0	8.5	3.9	.01	.01	.20	1.75

### TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	123,300 PSI
YEILD STRENGTH	97,400 PSI
ELONGATION	28%
CHARPY IMPACT (V-NOTCH)	90 FT. LBS. @ -40°C with PWHT

### WELDING PARAMETERS

DIAMETER	3/32"	1/8"	5/32"	3/16"
AMPS				
-FLAT	70-85	85-110	110-140	120-160
-VERTICAL	65-75	80-90	100-120	110-130

### PROCEDURE INFORMATION

- No special preheat, max interpass temperature 350°F in no PWHT
- Special heat input restriction – 5 KJ/inch min 40 KJ/inch max
- Avoid very rapid cooling for optimum weld metal properties
- PWHT (Post Weld Heat Treatment) – (Quench anneal) may be required for thick sections.

### STANDARD PACKAGING

- 3/32" 8 lb. can / 48 lb. box
- 1/8" 10 lb. can / 60 lb. box
- 3/16" 10 lb. can / 60 lb. box
- 5/32" 10 lb. can / 60 lb. box

*The contents of this publication are presented for informational purposes only, and while every effort has been made to ensure their accuracy, they are not to be construed as warranties or guarantees, express or implied, regarding the products or services described herein or their use or applicability. We reserve the right to modify or improve the designs or specifications of such products at any time without notice.*