



S. R. Industries

STAR ARC ER2553

ER2553 is used primarily to weld duplex stainless steels which contain approximately 25% chromium. It has a 'duplex' micro-structure consisting of an austenite-ferrite matrix. This duplex alloy is characterized by high tensile strength, resistance to stress corrosion cracking and improved resistance to pitting.

AWS Specification : AWS A5.9/A5.9M:2006

<i>AWS Classification</i>	<i>ER2553</i>
<i>Welding Current</i>	<i>DCEP</i>
Typical Wire Chemistry	
<i>C</i>	<i>0.04</i>
<i>Cr</i>	<i>24.0 - 27.0</i>
<i>Ni</i>	<i>4.5 - 6.5</i>
<i>Mo</i>	<i>2.9 - 3.9</i>
<i>Mn</i>	<i>1.5</i>
<i>Si</i>	<i>1.0</i>
<i>P</i>	<i>0.04</i>
<i>S</i>	<i>0.03</i>
<i>N</i>	<i>0.10 - 0.25</i>
<i>Cu</i>	<i>1.5 - 2.5</i>
Available Diameters MIG with Operating Range in Amps	
<i>.035"</i>	<i>100 - 150</i>
<i>.045"</i>	<i>150 200</i>
Available Diameters TIG with Operating Range in Amps	
<i>1/16"</i>	<i>90 - 130</i>

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<i>3/32"</i>	<i>120 - 175</i>
<i>1/8"</i>	<i>150 - 220</i>
<i>5/32"</i>	<i>170 - 350</i>

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