




# CEWELD CroNi 29/9 HLS

TYPE	Special alloy for welding unknown and difficult to weld steels.( Type 312, 29 9 , 1.4337)						
APPLICATIONS	CroNi 29/9 HLS is a austenitic-ferritic special alloy high recovery rutile electrode suitable for joining steels that are difficult to weld. Varied applications in repair and maintenance of machines, shafts, gearwheels, especially in the field of construction machinery. Also excellent for buffer layers before Hardfacing and for dissimilar welding between steel, stainless steels or unknown steels.						
PROPERTIES	Very popular because of its soft, stable arc, its easy spatter free application and the very good slag removal with no residues. High corrosion resistance and high temperature resistance up to 1100 °C. with excellent weldability on both AC and DC+.						
CLASSIFICATION	AWS	A 5.4: E 312-26					
	EN ISO	3581-A: E 29 9 R 53					
	F-nr	5					
	FM	5					
	W.Nr.	1.4337					
SUITABLE FOR	<b>ISO 15608: 11 (0,25 % &lt; C ≤ 0,85 %) Type: 29% Cr, 9%Ni</b> 1.3401, 1.4006, 1.4339, 1.4340, 1.4347, 1.4460 X120Mn12, X10Cr13, GX32CrNi28-10, GX49CrNi27-4, GX8CrCrNiN26-7, X3CrNiMoN27-5-2 UNS S41000 AISI 329, 410. S235, E295 Hss, C45, C60, dissimilar welding, maintenance, buffer layers, repairing cock wheels, 42MnV7, 25CrMo4, 42CrMo4, 50CrMo4, 1.5223, 1.7218, 1.7225, 1.7228, ArmoX, Hardox						
APPROVALS	CE						
WELDING POSITIONS	<div>PAPBPC</div>						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni
	0.1	0.8	2	0.025	0.015	30	9.5
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A5 (%)	Impact Energy (J) ISO-V RT	Hardness Brinell Hardness	
	As Welded /	500	750	23	40	Avg. 300	
REDRYING TEMPERATURE	Not required						
GAS ACCORDING EN 14175							