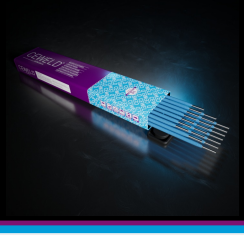

CEWELD CroNi 29-9 HLS

certilas® THE FILLER METAL SPECIALIST

TYPE

Special alloy for welding unknown and difficult to weld steels.(Type 312, 29 9 , 1.4337)

APPLICATIONS

CEWELD® CroNi 29-9 HLS is an austenitic-ferritic special alloy with a high rutile coating that is suitable for joining difficult-to-weld steels. It has a wide range of applications in the repair and maintenance of machines, shafts and gears, particularly in the construction machinery sector. Also excellent for buffer layers before overlay welding and for mixed welds between steel, stainless steels or unknown steels.

PROPERTIES

CEWELD® CroNi 29-9 HLS is very popular because of its soft, stable arc, easy, spatter-free application and very good, residue-free slag removal. High corrosion resistance and high temperature resistance up to 1100 °C with excellent weldability at 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

ISO 15608: 11 (0,25 % < C ≤ 0,85 %) Type: 29% Cr, 9%Ni
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

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	$R_{P0,2}$ MPa	Rm 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