


CEWELD CroNi 29-9 HLS

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	<table border="0"> <tr> <td>AWS</td> <td>A 5.4: E 312-26</td> </tr> <tr> <td>EN ISO</td> <td>3581-A: E 29 9 R 53</td> </tr> <tr> <td>F-nr</td> <td>5</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4337</td> </tr> </table>	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				
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F-nr	5														
FM	5														
W.Nr.	1.4337														
SUITABLE FOR	<p>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, GX8CrCrNi26-7, 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</p>														
APPROVALS	CE														
WELDING POSITIONS															
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>0.8</td> <td>2</td> <td>0.025</td> <td>0.015</td> <td>30</td> <td>9.5</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	0.1	0.8	2	0.025	0.015	30	9.5
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> <th>Impact Energy (J) ISO-V RT</th> <th>Hardness Brinell Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>500</td> <td>750</td> <td>23</td> <td>40</td> <td>Avg. 300</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT	Hardness Brinell Hardness	As Welded /	500	750	23	40	Avg. 300		
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REDRYING TEMPERATURE	Not required														
GAS ACCORDING EN 14175															