





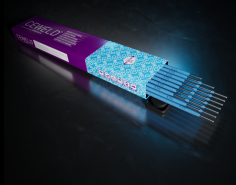


CEWELD CroNi 29/9 S

TYPE	29-9 welding electrode for buffer layers, dissimilar welding and difficult to weld steels. (Type 29 9, 312, 1.4337)							
APPLICATIONS	This austenitic-ferritic special alloy is suitable for joining steels that are difficult to weld. Varied application in repair and maintenance of machines, shafts, gearwheels, especially in the field of building machinery. Also excellent for buffer layers before Hardfacing and for dissimilar welding between steel, stainless steels or unknown steels. Very good corrosion resistance in wet, sulphurous environments, e.g. in sulphate fermenters in the paper industry.							
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 312-16						
	EN ISO	3581-A: E 29 9 R 12						
	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	<div></div>							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	FN
	0.1	0.8	1.5	0.02	0.015	30	9	38
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	
					RT		Brinell Hardness	
	As Welded /	500	750	23	40		Avg. 300	
REDRYING TEMPERATURE	300°C / 2 hr							
GAS ACCORDING EN 14175								



CEWELD CroNi 29/9 S

CRONI 29/9 S 1,6 X 250MM	Type	KG/unit	EANCode
	Can	2,1	8720663416322
CRONI 29/9 S 2,0 X 300MM	Type	KG/unit	EANCode
	Can	2,4	8720663416339
CRONI 29/9 S 2,5 X 300MM	Type	KG/unit	EANCode
	Can	2,4	8720663416346
CRONI 29/9 S 3,2 X 350MM	Type	KG/unit	EANCode
	Can	2,5	8720663416353
CRONI 29/9 S 4,0 X 350MM	Type	KG/unit	EANCode
	Can	2,5	8720663416360
CRONI 29/9 S 5,0 X 350MM	Type	KG/unit	EANCode
	Can	2,5	8720663416377