



CEWELD CroNi 29-9 HLS

TYPE	Special alloy for welding unknown and difficult to weld steels.						
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.						
PROPRIÉTÉS	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					
	W.Nr.	1.4337					
	F-nr	5					
	FM	5					
CONVIENT POUR	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						
AGRÉMENTS	CE						
POSITIONS DE SOUDAGE	PA PB PC						
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	P	S	Cr	Ni
	0.1	0.8	2	0.025	0.015	30	9.5
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
	As Welded	500	750	23	RT		
					40		300 HB
ETUVAGE	Not required						
GAS ACC. EN ISO 14175							