



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, 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

AGRÉMENTS CE

POSITIONS DE SOUDAGE



**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
				RT	
As Welded	500	750	23	40	300 HB

ETUVAGE Not required

GAS ACC. EN ISO 14175