



CEWELD CroNiMo HLS

TYPE High recovery Stainless steel stick electrode for welding dissimilar joints. (Type 308Mo, E 20 10 3)

APPLICATIONS CEWELD® CroNiMo HLS is a high recovery rutile/basic stick electrode of type E 20 10 3 R / E308Mo-16 with basic components for ferrite and austenitic joints and intermediate layers for weld claddings.
Mixed joints between structural, fine-grained structural and quenched and tempered steels with high-alloy Cr and CrNi(Mo) steels; austenitic manganese steels with each other and with other steels.

PROPERTIES CEWELD® CroNiMo HLS has good corrosion resistance to seawater and general corrosion with excellent welding properties and self-releasing slag.

CLASSIFICATION

AWS	A 5.4: E 308Mo-26
EN ISO	3581-A: E 20 10 3 RB 53
W.Nr.	1.4431
F-nr	1
FM	5

SUITABLE FOR **W.Nr:** 1.4311, 1.4401, 1.4404, 1.4408, 1.4571, 1.4573, 1.4580, 1.4581, 1.4712, 1.4742, 1.4828, X 12 CrNi 22 12, X5CrNiMo17-12-2, X2CrNiMo17-12-2, G-X5CrNiMo19-11-2, X6CrNiMoTi17-12-2, X10CrNiMoTi18-12, X6NiCrMoNb17-12-2, G-X5CrNiMoNb19-11-2
NFA 35-578 : Z 15 CN 24.13
ASTM/AISI : 304, 347, 309, 316, 316L, 316Ti, 316Cb
UNS: S31600, S31603, J92900, S31635, S31640
UGINE : NS 24, R 27. A, UGINOX 17-10 M, UGINOX 18-11 ML, UGINOX 17-11 MT
+ for dissimilar joints between low alloy/mild steels and stainless steels.

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.07	0.8	2	0.025	0.015	20	11	2.5

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	430	600	35	70	HRc

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD CroNiMo HLS

CRONIMO HLS 2,5 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663416445