



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 CEWELD® CroNi 29-9 S is an austenitic-ferritic special alloy that is suitable for joining difficult-to-weld steels. It has a wide range of applications such as the repair and maintenance of machines, shafts and gear wheels, particularly in the construction machinery sector. It is also excellent for buffer layers before overlay welding and for dissimilar welds between steel, stainless steels or unknown steels. Very good corrosion resistance in damp, sulphurous environments, e.g. in sulphate digesters in the paper industry.

PROPERTIES CEWELD® CroNi 29-9 S is very popular because of its soft, stable arc and its easy spatter-free application with very good slag removal without residues. High corrosion resistance and high temperature resistance up to 1100 °C with excellent weldability at both AC and DC+.

CLASSIFICATION

AWS	A 5.4: E 312-16
EN ISO	3581-A: E 29 9 R 12
W.Nr.	1.4337
F-nr	5
FM	5

SUITABLE FOR **ISO 15608: 8 >19% Cr Type: 29% Cr, 9%Ni**
1.4762, 1.4085
X120Mn12, X10Cr13, GX32CrNi28-10, GX49CrNi27-4, GX8CrCrNi26-7, X3CrNiMoN27-5-2, X 10 CrAl 24, G-X 70 Cr 29
UNS S41000
AISI 329, 410. S235, E295
Hss, C45, C60, dissimilar welding S335 - X120Mn12, maintenance, buffer layers, repairing cock wheels, 42MnV7, 25CrMo4, 42CrMo4, 50CrMo4, 1.5223, 1.7218, 1.7225, 1.7228, Armox, Hardox

APPROVALS CE

WELDING POSITIONS



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

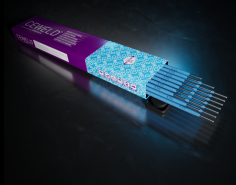
MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	500	750	23	40	300 HB

REDRYING 300°C / 2 hr

CURRENT TYPE AC / DC+

GAS ACC. EN ISO 14175



CEWELD CroNi 29-9 S

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