



CEWELD CroNi 29-9 HLS

certilas® THE FILLER METAL SPECIALIST

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, Armax, Hardox																	
AGRÉMENTS	CE																	
POSITIONS DE SOUDAGE	  																	
ANALYSE CHIMIQUE TIPIQUE DU MÉTAL DE SOUDURE (%)	<table border="1" style="width: 100%; text-align: center;"> <thead> <tr> <th>C</th><th>Si</th><th>Mn</th><th>P</th><th>S</th><th>Cr</th><th>Ni</th></tr> </thead> <tbody> <tr> <td>0.1</td><td>0.8</td><td>2</td><td>0.025</td><td>0.015</td><td>30</td><td>9.5</td></tr> </tbody> </table>		C	Si	Mn	P	S	Cr	Ni	0.1	0.8	2	0.025	0.015	30	9.5		
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GAS ACC. EN ISO 14175																		