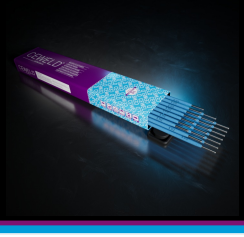


CEWELD CroNi 29-9 S

certilas® THE FILLER METAL SPECIALIST

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, GX8CrCrNiN26-7, 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

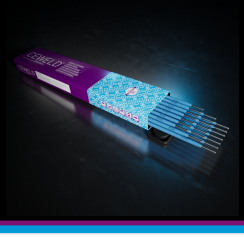
REDRYING

300°C / 2 hr

CURRENT TYPE

AC / DC+

GAS ACC. EN ISO 14175



CEWELD CroNi 29-9 S

certilas® THE FILLER METAL SPECIALIST

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