

# CEWELD CroNi 29-9 HLS

**TYPE** Special alloy for welding unknown and difficult to weld steels.( Type 312, 29 9 , 1.4337)

**APPLICATIONS** CEWELD® CroNi 29-9 HLS is an austenitic-ferritic special alloy with a high rutile coating that is suitable for joining difficult-to-weld steels. It has a wide range of applications in the repair and maintenance of machines, shafts and gears, particularly in the construction machinery sector. Also excellent for buffer layers before overlay welding and for mixed welds between steel, stainless steels or unknown steels.

**PROPERTIES** CEWELD® CroNi 29-9 HLS is very popular because of its soft, stable arc, easy, spatter-free application and very good, residue-free slag removal. High corrosion resistance and high temperature resistance up to 1100 °C with excellent weldability at both AC and DC+.

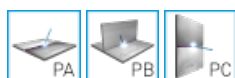
**CLASSIFICATION**

AWS	A 5.4: E 312-26
EN ISO	3581-A: E 29 9 R 53
W.Nr.	1.4337
F-nr	5
FM	5

**SUITABLE FOR** **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

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	S	Cr	Ni
0.1	0.8	2	0.025	0.015	30	9.5

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	500	750	23	40		300 HB

**REDRYING** Not required

**GAS ACC.** EN ISO 14175