



CEWELD CroNiMo HLS

TYPE	High recovery Stainless steel stick electrode for welding dissimilar joints.	
APPLICATIONS	Cronimo HLS is a high recovery rutile/basic electrode for welding dissimilar steels. Suitable for welding low-alloyed steel to stainless or austenitic manganese steels. Maintenance and repair welding of unknown or difficult to weld steels.	
PROPRIÉTÉS	Good corrosion resistance against seawater and general corrosion with excellent welding properties with self detaching 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
CONVIENT POUR	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.	

AGRÉMENTS CE

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL DE
SOUDURE (%)

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

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	430	600	35	70	HRc

ETUVAGE 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