

# 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 |

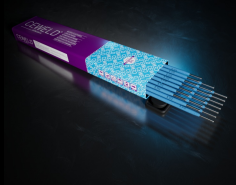
**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (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 |