



# CEWELD CroNi 29-9 HLS

TYPE

APPLICATIONS

PROPERTIES

CLASSIFICATION

SUITABLE FOR

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

MECHANICAL PROPERTIES

REDRYING

GAS ACC. EN ISO 14175

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

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.

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+.

AWS  
EN ISO  
W.Nr.  
F-nr  
FM

A 5.4: E 312-26  
3581-A: E 29 9 R 53  
1.4337  
5  
5

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, GX8CrCrNiN26-7, 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, Armox, Hardox

CE

PA

PB

PC

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

|                |                            |                         |           |                         |  |          |
|----------------|----------------------------|-------------------------|-----------|-------------------------|--|----------|
| Heat Treatment | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Impact Energy (J) ISO-V |  | Hardness |
|                |                            |                         |           | RT                      |  |          |
| As Welded      | 500                        | 750                     | 23        | 40                      |  | 300 HB   |

Not required