

Croni 29/9 S

CATEGORY SMAW Stick Electrodes

TYPE Special alloy for welding unknown and difficult to weld steels.

APPLICATIONS This austenitic-ferritic special alloy is suitable for joining steels that are difficult to weld. Varied application in repair and maintenance of machines, shafts, gearwheels, especially in the field of building machinery. Also excellent for buffer layers before hardfacing and for dissimilar welding between steel, stainless steels or unknown steels.

PROPERTIES Very popular because of its soft, stable arc, its easy spatter free application and the very good slag removal with no residues. High corrosion resistance and high temperature resistance up to 1100°C. with excellent weldability on both AC and DC+.

CLASSIFICATION

AWS	A 5.4: E 312-16
EN ISO	3581-A: E 29 9 RB 12
DIN: W.Nr.	1.4337
DIN	8556: E 29 9 R 23

SUITABLE FOR Manganese steel, spring steel, high speed tool steels, hss, C45, C60, dissimilar welding, maintenance, buffer layers, repairing cock wheels, 42MnV7, 25CrMo4, 42CrMo4, 50CrMo4, 1.5223, 1.7218, 1.7225, 1.7228, stainless steel, difficult to Weld steel, unknown steel,

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL WEIGHT %

C	Mn	Si	Cr	Ni	
-	0.8	-	27.50	8.0	min
0,10	1.2	-	30.0	10.0	max

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V	Impact Joule	Hardness HB
AW	>630	>810	>20	20°C -40°C		200-220

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / parcel	kg / 6pack	kg / 1000
1.6	275	40-60	2.0	12	
2.0	300	50-70	2.4	14.4	
2.5	350	70-90	2.4	14.4	
3.2	350	90-130	2.5	15	
4.0	450	120-180	2.5	15	
5.0	450	170-220	2.5	15	

REDRYING TEMPERATURE 300°C/2hr (not often required)