

Cronimo Ti

CATEGORY	SMAW Stick Electrodes								
TYPE	A rutile-basic all position electrode for welding dissimilar joints.								
APPLICATIONS	Joining steels difficult to weld and dissimilar welding between steel and stainless steel.								
PROPERTIES	The general purpose electrode for repair welding Suitable for hobby and professional applications. Easy slag release and smooth bead appearance.								
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.4: E 308Mo-16</td> </tr> <tr> <td>EN ISO</td> <td>ISO 3581-A E 20 10 3 L RB 12</td> </tr> <tr> <td>DIN: W.Nr.</td> <td>1.4431</td> </tr> <tr> <td>DIN</td> <td>8556: E 19 9 3 R 23</td> </tr> </table>	AWS	A 5.4: E 308Mo-16	EN ISO	ISO 3581-A E 20 10 3 L RB 12	DIN: W.Nr.	1.4431	DIN	8556: E 19 9 3 R 23
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DIN: W.Nr.	1.4431								
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SUITABLE FOR	High-strength, mild steels and low-alloyed constructional steels, QT-steels and armour plates among themselves or among each other; non-alloy as well as alloyed boiler or constructional steels with high-alloy stainless Cr- and Cr-Ni-steels; austenitic manganese steels similar and dissimilar. Steel to stainless steel, stainless steel, dissimilar welding joints,								
APPROVALS	CE approved								

WELDING POSITIONS:



ALL WELD DEPOSIT ANALYSIS

C	Mn	Si	Cr	Ni	Mo
0.025	0.8	0.7	20	9.5	2.3

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				+20°C	-20°C	-80°C	
as welded	500	720	30	70	60	>32	

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	300	40-75	2.5	15	19
3.2	350	60-110	2.6	15.6	36
4.0	350	80-150	2.8	16.8	55
5.0	450	155-220	3.2	19.2	107

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