



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



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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