

Selectarc 29/9

Stainless Electrode For repairing

| Classification | |
|---|------------------------|
| AWS A5.4 : ~ E312-16 ISO 3581-A : E 29 9 R 3 2 | EN 1600 : E 29.9 R 3 2 |
| Departmention 9 Applications | |

Description & Applications

Rutile-basic electrode with an austenitic-ferritic stainless steel deposit, adapted for welding dissimilar steels (stainless steels with low alloyed steels) and steels difficult to weld as tool steels, Mn steels, spring steels... Metal deposit highly resistant to cracks, suitable for buffer layers before hardfacing and for building up cutting tools. Soft fusion, nice aspect of the beads, self releasing slag.

Base materials

| Stainless steels | | | | | |
|--|---|--|--|--|--|
| To <mark>ol</mark> steels | | | | | |
| Low alloyed steels | | | | | |
| Austenitic steels with Mn | : | Z 120 M 12 type, X 120 Mn 12, 1.3401 | | | |
| Screening steels | | | | | |
| Spring steels | : | 45 Cr 4, 1.7035, 46 Si 7, 1.5024, 51 Si 7, | | | |
| | | 1.5025, 56 Si 7, 1.5026 | | | |
| Armatures and wire lattice for reinforced concrete | | | | | |
| | | | | | |

| Typical Weld Metal Composition (%) | | | | | | | |
|--------------------------------------|-----|-----|------|-----|-----|------|--|
| С | Si | Mn | Cr | Ni | Мо | Fe | |
| 0.1 | 1.0 | 0.6 | 29.0 | 9.5 | 0.5 | Rem. | |

| All Weld Metal Mechanical Properties | | | | | |
|--------------------------------------|------------------------|--------------------|----------------|--|--|
| R _{p0.2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness | | |
| >500 | 700-850 | >20 | Approx. 240 HB | | |

Welding Current & Instructions

| Electrode | ØxL (mm) | 1,6x250 | 2,0x300 | 2,5x300 | 3,2x350 | 4,0x350 | 5,0x450 |
|-----------|----------|---------|---------|---------|---------|---------|---------|
| Current | (A) | 35 | 45 | 70 | 110 | 135 | 180 |

Redrying 2 hours at 250°C, if necessary. Interpass temperature : < 250°C.

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