



# 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 <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	430	600	35	70		HRc

**ETUVAGE** 300°C / 2 hr

**GAS ACC. EN ISO 14175**



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CRONIMO HLS 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663416445