



Selectarc 29/9

*Stainless Electrode
For repairing*

Classification

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

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

Tool 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 (%)

C	Si	Mn	Cr	Ni	Mo	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.

ind.12



= + ~ 50V

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