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**Stainless Electrode
for repairing**



FSH WELDING GROUP
INNOVATIVE WELDING CONSUMABLES
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Classification

AWS A5.4 : ~ E312-16 ISO 3581-A : E 29 9 R 32
EN 1600 : E 29.9 R 32

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
0.1	1.0	0.6	29	9.5	0.5

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



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

= + ~ 50V



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