




# CEWELD CroNiMo Ti

TYPE	Rutile basic Stainless steel stick electrode for welding dissimilar joints.																		
APPLICATIONS	CEWELD® CroNiMo Ti is a rutile coated stick electrode of type E 20 10 3 R / E308Mo-16 with basic components for ferrite and austenitic joints and intermediate layers for weld claddings. Mixed joints between structural, fine-grained structural and quenched and tempered steels with high-alloy Cr and CrNi(Mo) steels; austenitic manganese steels with each other and with other steels.																		
PROPERTIES	CEWELD® CroNiMo Ti has good corrosion resistance to seawater and general corrosion with excellent welding properties and self-releasing slag. Highly crack resistant.																		
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.4: E 308Mo-16</td> </tr> <tr> <td>EN ISO</td> <td>3581-A: E 20 10 3 RB 32</td> </tr> <tr> <td>W.Nr.</td> <td>1.4431</td> </tr> <tr> <td>F-nr</td> <td>5</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.4: E 308Mo-16	EN ISO	3581-A: E 20 10 3 RB 32	W.Nr.	1.4431	F-nr	5	FM	5								
AWS	A 5.4: E 308Mo-16																		
EN ISO	3581-A: E 20 10 3 RB 32																		
W.Nr.	1.4431																		
F-nr	5																		
FM	5																		
SUITABLE FOR	<p><b>W.Nr:</b> 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</p> <p><b>NFA 35-578 :</b> Z 15 CN 24.13</p> <p><b>ASTM/AISI :</b> 304, 347, 309, 316, 316L, 316Ti, 316Cb</p> <p><b>UNS:</b> S31600, S31603, J92900, S31635, S31640</p> <p><b>UGINE :</b> NS 24, R 27. A, UGINOX 17-10 M, UGINOX 18-11 ML, UGINOX 17-11 MT</p> <p><b>+ for dissimilar joints between low alloy/mild steels and stainless steels.</b></p>																		
APPROVALS	CE																		
WELDING POSITIONS																			
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.07</td> <td>0.8</td> <td>2</td> <td>0.025</td> <td>0.015</td> <td>20</td> <td>11</td> <td>2.5</td> <td>Rem.</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	Fe	0.07	0.8	2	0.025	0.015	20	11	2.5	Rem.
C	Si	Mn	P	S	Cr	Ni	Mo	Fe											
0.07	0.8	2	0.025	0.015	20	11	2.5	Rem.											
MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0.2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>420</td> <td>600</td> <td>35</td> <td colspan="2">70</td> <td>HRC</td> </tr> </tbody> </table>	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	420	600	35	70		HRC		
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	420	600	35	70		HRC													
REDRYING	300°C / 2 hr																		
GAS ACC. EN ISO 14175																			



# CEWELD CroNiMo Ti

CRONIMO TI 2,0 X 300MM	Packaging	KG/unit	EanCode
	Can	2,4	8720663416391
CRONIMO TI 2,5 X 300MM	Packaging	KG/unit	EanCode
	Can	2,2	8720663416407
CRONIMO TI 3,2 X 350MM	Packaging	KG/unit	EanCode
	Can	2,6	8720663416414
CRONIMO TI 4,0 X 350MM	Packaging	KG/unit	EanCode
	Can	2,8	8720663416421
CRONIMO TI 5,0 X 450MM	Packaging	KG/unit	EanCode
	Can	3,2	8720663416438