

Classifications

EN ISO 3581-A	AWS A5.4 / SFA-5.4
E 29 9 R 1 2	E312-16

Characteristics and typical fields of application

Rutile basic electrode of type 29 % Cr 9% Ni / E312. BÖHLER FOX CN 29/9 is a repair & maintenance electrode that offers outstanding operating characteristics and weld metals of high strength combined with high crack resistance when welding problem steels or dissimilar joints. The weld metal also work hardens making it suitable for wear resisting build-ups on clutches, gear wheels, shafts, etc. Also suitable for repair welding of tools.

Base materials

For problem steels with high strength, joining of dissimilar materials, tool steels, heat treatable or quenched and tempered steels, spring steels, high carbon steels etc.

Typical analysis

	C	Si	Mn	Cr	Ni
wt.-%	0.11	1.0	0.7	29.0	10.2

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)
	MPa		%
u	640 (≥ 450)	790 (≥ 660)	23 (≥ 15)
u untreated, as welded			

Operating data

Polarity	DC+ / AC	Dimension mm
Electrode identification	FOX CN 29/9 E 29 9 R	2.5 × 300
		3.2 × 350
		4.0 × 350
		5.0 × 450

Approvals

DB (30.014.11), SEPROZ, CE