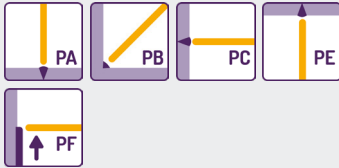


Processing information

Re-drying: 300 – 350 °C/2 h

Welding positions:



Polarity:



Whether preheating is required depends on the base material, for low dilution low heat input required. Otherwise preheating not necessary. Interpass temperature max. 200 °C.

Application

FINOX 29/9 Gold is a special electrode for extremely crack-resistant joint and surface welding on difficult-to-weld steels, e.g. hard-manganese steel, tool steel and spring steel as well as mixed joints, e.g. black-and-white joints. Due to its good mechanical properties and corrosion-resistance the electrode can be used for a wide range of applications, i.e. repair and maintenance of machine parts and plant components like shafts and cog wheels as well as for tools. The electrode is just as well suited for buffering layers under hard alloys. Due to a stable arc the electrode has excellent welding properties, creates a finerippled, easy-to-shape seam with easy-to-remove slag. The weld metal is stainless, warm-hardenable and work-hardenable.

Field



Characteristic
rutile-coated,
core wire-alloyed

Standards
ISO 3581-A
E Z 29 9 R 12

EN 14700
E Fe 11

AWS A 5.4
= E 312-16

Material no.
= 1.4337

Approvals



All Weld Metal Mechanical Properties

Heat Treatment AW

Structure Austenite / Ferrite

Weld Metal Composition [%]

C	Si	Mn	Cr	Ni
0,1	0,7	1	30	9,5

Yield Strength Rp 0,2 [MPa] > 640

Tensile Strength Rm [MPa] > 800

Elongation A5 [%] > 20

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.732.250	2,50/300	80 - 110	4,0	238	16,8
00.732.323	3,25/350	100 - 140	5,0	154	32,5
00.732.403	4,00/350	130 - 170	5,0	99	50,5



[kjellberg.de](http://www.kjellberg.de)

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