

Cronimo Ti

CATEGORY SMAW Stick Electrodes

APPLICATIONS Rutile low carbon electrode for welding low-alloyed steel to stainless or austenitic manganese steels, it is suitable for stainless cladding. Weld metal has corrosion resistance to acids and salt water

CLASSIFICATION

AWS	A 5.4: E 308Mo-16
EN ISO	ISO 3581-A E 20 10 3 R32
DIN: W.Nr.	1.4431
DIN	8556: E 20 10 3 R23

SUITABLE FOR NF A 35-578 : Z 15 CN 24.13 ASTM/AISI : 304, 347, 309 DIN 17175 : X 12 CrNi 22.12. Werkstoff Nr : 1.4828, 1.4311, 1.4712, 1.4742. UGINE : NS 24, R 27. All construction steels , low alloyed in combination with stainless steels.

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Cr	Ni	Mo	Fe
0.03	18-20	9-11	2.5-3.5	Rest

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V		
				+20°C	-40°C	-60°C
AW	400	600	>30	60		

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.0	300	40-60	2.4	14.4	
2.5	300	50-90	2.2	13.2	
3.2	350	80-110	2.6	15.6	

REDRYING TEMPERATURE 300°C/2h