

Classifications

ISO 3581	AWS A5.4	Material-No.
EZ 29 9 R 12	E 312 – 16 (mod.)	1.4337

Characteristics and field of use

UTP SUPERCROM 29/9 is a rutile coated stick electrode for joining and cladding; finds a variety of applications in the repair and maintenance of machine and drive components (shafts, gears, housings), in particular on construction machinery. Also suitable for heterogeneous welding.

It can be welded in awkward positions. Stable arc, free of spattering. Very good slag removal. Finely rippled seams without undercuts. Work-hardening.

Base materials

DIN designation	Material-No.
X10 CrAl24	1.4762
G – X70 Cr29	1.4085
G – X32 CrNi28 10	1.4339
G – X40 CrNi27 4	1.4340
G – X8 CrNi26 7	1.4347

Joining of these materials with low and non-alloyed steels is allowed.

Typical analysis in %

C	Si	Mn	Cr	Ni	Fe
0.10	1.25	0.7	29.2	10.5	balance

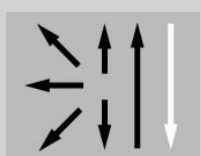
Mechanical properties of the weld metal

Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A	Impact toughness
N/mm ²	N/mm ²	%	K _v (+20 °C)
> 590	> 750	> 22	50

Welding instruction

Clean the workpiece. The electrode should be held slightly inclined, keep a short arc. Preheating is not necessary in most cases. Re-drying 200 °C during 2h.

Welding positions



Current type DC (+) / AC

Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	4.0 x 350
Amperage [A]	100 – 165