

Standards:

EN14700:	E Fe 10-200/400-cnz
EN ISO 3581-A:	E 18 8 Mn R 52
EN 1600:	E 18 8 Mn R 52
AWS A 5.4:	~ E 307-26
Mat.-No.:	1.4370

Recovery: 160%

Product description:

Rutile-basic coated high recovery stick electrode suitable for fusion welding of dissimilar joints and cladding of mild steel.

The Cr-Ni-Mn-alloyed weld metal has a fully of austenitic structure and can be strainhardened.

Service temperatures in corrosive media:
up to 300 °C.

Scaling resistant: up to 900 °C.

Applications:

Fusion welding of dissimilar ferritic-austenitic joints; welding of "hard-to-weld"-steels having a high C-content, e.g. rail steels, fusion welding of strain hardening Mn-steels, e.g. X 120 Mn 12 (1.3401).

Buffer layers of hardfacings.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mn	Fe
Min.		17	7	5	
Max.	0,1	19	9	7	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	600	[MPa]
Yield strength $R_{p0,2}$:	350	[MPa]
Yield strength $R_{p1,0}$:	400	[MPa]
Elongation (L=5d):	40	[%]
Impact strength (ISO-V):	70	[J]

Positions: all except PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,5	350	60 – 90	=(+)-
3,25	350	80 – 110	
4,0	350	100 – 150	
5,0	350/450	150 – 200	

also available:

find in table of content

Capilla 51 Kb
Capilla 51 Ti
Capilla 51 MAG

Capilla 51 WIG
Capilla G 51 MM
Capicoat 51