

Standards:

EN ISO 3581-A:	E 17 B 42
EN 1600:	E 17 B 42
AWS SFA-5.4:	E 430 - 25
Mat.-Nr.:	1.4015

Recovery: 150%

Product description:

Basic coated stick electrode suitable for overlays of sealing surfaces at gas-, water- and steam-fittings up to service temperatures of 450°C.

The weld metal has a comparable corrosion resistance as similar alloyed chromium steels.

Scaling resistant up to 950°C.

It is recommended to preheat the work piece to approx. 250°C before welding.

A stress-relief-heat treatment up to temperatures of $T_{PWHT} = 800^{\circ}\text{C}$ is recommended if T_{PWHT} is not limited by the properties of the base metal.

Applications:

The electrode is suitable for overlay and fusion welding of heat treatable steels alloyed with 17 % chromium.

Often used as cover pass on tough austenitic filler passes (e.g in sulphurous media at elevated temperatures).

Suitable for materials like:

1.4057, 1.4740, 1.4742, 1.4059, 1.4741.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mn	Fe
Min.		16	0,5	
Max.	0,1	18	1	Bal.

Mechanical properties:

(Heat treatment: 800°C/1h; Minimum values at ambient temperature)

Tensile strength R_m :	540	[MPa]
Yield strength $R_{p0,2}$:	340	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	20	[%]
Hardness:	150	[HB 30]
	240	[HB 30] without heat treatment

Positions: all except PD, PE and 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	

also available:
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Capilla 4015 MAG
Capilla 4015 WIG
Capidur 4015