

Standards: EN 14700: E Fe 3-50-st (DIN 8555): E 3-UM-50-T		capilla® 25 S
Recovery:	140%	

Product description: Rutile-basic coated high-recovery stick electrode for overlay welding on hot forming tools. The weld metal is extremely resistant to abrasion, impact and pressure.	Applications: This electrode is used for repair welding of hot-forming tools, especially dies. Also qualified for new production and the change of surface design of tools. Furthermore suitable for hard-facing of cutting edges of cold shearing tools.
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Typical weld metal composition:

[wt. - %]

	C	Cr	W	Co	V	Nb	Fe
Min.		2	8	1	0,3		
Max.	0,3	2,5	9	1,5	0,6	0,4	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Hardness:	46 – 48 52 – 55	[HRC] as welded [HRC] annealed(550°C/2-8h)
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Positions: all except PD, PE and PG

Redrying: 300 - 320°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity = (+) ~
	2,5	350	80 – 120	
	3,25	350	100 – 160	
	4,0	450	160 – 220	
	5,0	450	190 – 260	
	6,0	450	220 – 290	

also available:
find in table of content

Capilla G 563 MM (tubular wire)