

Standards:EN 14700:
(DIN 8555):E Fe 5-40-stp
E 4-UM-40 PT**capilla® 2709****Recovery:****160%****Product description:**

Basic coated high-recovery stick electrode, especially suitable for welding hard or hard/tough overlays. The weld metal is very resistant to metal-metal-friction wear.

Service temperature: max. 350°C

(Maraging steel).

Applications:

Overlays at metal shear blades, die stamps, cold extrusion tools, die casting moulds and plastic moulds.

Typical weld metal composition:

[wt. - %]

	C	Ni	Co	Mo	Mn	Si	Ti	Al	Fe
Min.		17	10	4					
Max.	0,03	19	12	4,5	0,3	0,8	+	+	Bal.

Mechanical properties:

(Minimum values at ambient temperature)

Hardness:

38 – 40

[HRC] as welded

53 - 54

[HRC] annealed (480°C/3h)

Positions:

PA, PB, (PC)

Redrying:

300 – 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	350	80 – 120
3,25	350	100 – 160
4,0	350	160 – 220

Polarity

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also available:

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Capilla 2709 MAG

Capilla 2709 WIG