

Standards:

EN ISO 2560-A: E 42 0 RR 53
 (EN 499): E 42 0 RR 53
 (DIN 1913): E 51 22 RR 11 160
 AWS A 5.1: E 7024-1

capilla® 30-170**Recovery:****165%****Product description:**

Rutile coated stick electrode with very high recovery. The high deposition rate of this consumable grant economical welding of fillets. Concave shape of fillet welds. Good bridging over of gaps. The slag is easy to remove.

Applications:

Fusion welding of general purpose constructional steel, boiler plates, pipe steel, ship structural steel, high tensile steel and cast steel such as:

S 185 - S 355 JOC,
 P 235 GH, P 265 GH, P 295 GH,
 P 210 N - P 360 N,
 S 255 NH - S 355 NH,
 P 255 NH - P 355 NH,
 GS 38 - GS 52.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Fe
Min.				
Max.	0,08	0,6	0,3	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	520	[MPa]
Yield strength $R_{p0.2}$:	420	[MPa]
Yield strength $R_{p1.0}$:	-	[MPa]
Elongation (L=5d):	22	[%]
Impact strength (ISO-V):	80	[J]

Positions:

PA, PB, PC

Redrying:

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Dimension:

Ø [mm]	Length [mm]	Welding current [A]
3,25	350	90 – 130
4,0	350	140 – 180
5,0	450	180 – 240

Polarity

=(-)~

also available:

find in table of content

Capilla 30 MAG
 Capilla 30 WIG
 Capilla 30 K RLD (tubular wire)