

Standards:

EN ISO 3581-A: E 23 12 R 32
 EN 1600: E 23 12 R 32
 AWS A 5.4: E 309 -26
 Mat.-No.: ~1.4829

Recovery: 120%

capilla® 309

Product description:

Rutile-basic coated stick electrode for fusion welding of heat resistant Cr-Ni steels.

Also suitable for fusion welding of dissimilar steels (high alloyed to low alloyed steels).

The weld metal is heat resistant up to 1050°C.

Also appropriate for overlay weldings of non-alloyed steels, if an 18/8 Cr-Ni alloy shall be realised in the first layer.

Applications:

Claddings, buffer layers and joints

Base materials:

1.4710, 1.4729, 1.4740, 1.4825,
 1.4828, 1.4878, 1.4780, 1.4541,
 1.4550, 1.4712, 1.4724, 1.4742,
 1.4826

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Fe
Min.		21	11	
Max.	0,08	23	13	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	550	[MPa]
Yield strength R _{p0,2} :	400	[MPa]
Yield strength R _{p1,0} :	430	[MPa]
Elongation (L=5d):	30	[%]
Impact strength (ISO-V):	55	[J]

Positions: all except PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	300	40 – 60	= (+) ~
2,5	300	60 – 90	
3,25	350	80 – 110	
4,0	350	100 – 150	
5,0	450	150 – 200	

also available:
 find in table of content

Capilla 309 MAG
 Capilla 309 WIG

Capilla G 309 RM (tubular wire)