

Standards:

DIN EN ISO 2560-A: E 42 0 RC 11
 (EN 499): E 42 0 RC 11
 AWS SFA-5.1: E 6013

capilla® 30 S**Approvals:****TUV, DB****Product description:**

Medium-thick rutile-cellulose coated stick electrode for assembly and maintenance welding in all positions, especially suitable for vertical down welding. Good bridging over of gaps. Using recommended welding parameters leads to self-removing slag.

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	0,5	0,3	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	510	[MPa]
Yield strength $R_{p0.2}$:	380	[MPa]
Yield strength $R_{p1.0}$:	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	50	[J]

Positions: all

Redrying: -

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	250	50 – 60	= (-) ~
2,5	350	60 – 85	
3,25	350	90 – 130	
4,0	350	140 – 180	
5,0	350	180 – 240	

also available:

find in table of content

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