

Standards:

EN ISO 3581-A: E 25 20 B 12
 EN 1600: E 25 20 B 12
 AWS A 5.4: E 310-15
 Mat.-No.: ~1.4842

capilla® 310 KB

Product description:

Basic coated electrode for welding of heat resistant austenitic steels.

The weld metal is fully austenitic and scaling resistant up to 1200°C.

Deposited material is not resistant to sulphurous gases.

Applications:

Suitable for materials as:

1.4832, 1.4837, 1.4840, 1.4841,
 1.4845, 1.4846, 1.4849, 1.4848,
 1.4828, 1.4713, 1.4726, 1.4710,
 1.4745, 1.4823

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mn	Fe
Min.		23	19	2,5	
Max.	0,1	26	21	3	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	570	[MPa]
Yield strength $R_{p0,2}$:	380	[MPa]
Yield strength $R_{p1,0}$:	410	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	40	[J]

Positions: all except PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	250/300	60 – 90	= (+) ~
2,5	300	80 – 110	
3,25	350	100 – 150	
4,0	350	150 – 190	
5,0	350	160 – 210	

also available:
 find in table of content

Capilla 310
 Capilla 310 MAG

Capilla 310 WIG