

Standards:

EN ISO 3581-A: E 20 25 5 Cu L R 32
 EN 1600: E 20 25 5 Cu LR 23
 AWS A 5.4: E 385 L-26
 Mat.-No.: ~1.4519

capilla® 385**Product description:**

Rutil-basic coated stick electrode for fusion and overlay welding of similar alloyed corrosion resistant steels. High resistance against phosphoric acid and stress corrosion cracking in fluids containing chlorides.

Applications:

Suitable for materials like:

1.4500, 1.4505, 1.4506, 1.4531,
 1.4539, 1.4573, 1.4585, 1.4586,

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mo	Mn	Cu	Fe
Min.		19	24	4	1,2	1,2	
Max.	0,03	21	26	5	1,8	1,8	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	600	[MPa]
Yield strength $R_{p0,2}$:	410	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	30	[%]
Impact strength (ISO-V):	40	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	300	80 – 110
3,25	350	100 – 150
4,0	350	150 – 200
5,0	450	160 – 210

Polarity
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also available:
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Capilla 385 MAG
 Capilla 385 WIG