Standards:

EN ISO 3581-A:	E 13 B 42
EN 1600:	E 13 B 42
AWS SFA-5.4:	E 410 - 25
Mat.-No.:	1.4009
Recovery:	**150%**

capilla® 4009

Product description:

Basic coated stick electrode for overlay and fusion welding of ferritic-martensitic chromium steels.
This stick electrode is suitable for overlays of sealing surfaces of gas-, water- and steam-fittings up to service temperatures of 450°C.
The weld metal is corrosion resistant as similar alloyed chromium steels.
If the base metal does not require a higher preheating temperature, T_{PH} = 200°C is recommended.

Applications:

The electrode shows an excellent suitability for overlay and fusion welding of 13 % Cr-steels.

Suitable for materials like:

1.4000, 1.4001, 1.4002, 1.4006, 1.4021, 1,4024.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mn	Fe
Min.		**11,5**		
Max.	**0,1**	**14,5**	**0,7**	**Bal.**

Mechanical properties:

(Heat treatment: 680°C/8h; Minimum values at ambient temperature)

Tensile strength R_m:	650	[MPa]
Yield strength $R_{p0,2}$:	450	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	15	[%]
Hardness:	180	[HB 30]
	35	[HRC] without heat reatment

Positions: all except PD, PE and PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	350	60 – 90
3,25	350	80 – 110
4,0	350	100 – 150

Polarity =(+)

also available:
find in table of content

Capilla 4009 MAG
Capilla 4009 WIG