

Standards:		capilla® 4015
EN ISO 3581-A:	E 17 B 42	
EN 1600:	E 17 B 42	
AWS SFA-5.4:	E 430 - 25	
Mat.-Nr.:	1.4015	
Recovery:	150%	

Product description:	Applications:
Basic coated stick electrode suitable for overlays of sealing surfaces at gas-, water- and steam-fittings up to service temperatures of 450°C. The weld metal has a comparable corrosion resistance as similar alloyed chromium steels. Scaling resistant up to 950°C. It is recommended to preheat the work piece to approx. 250°C before welding. A stress-relief-heat treatment up to temperatures of $T_{PWHT} = 800^{\circ}\text{C}$ is recommended if T_{PWHT} is not limited by the properties of the base metal.	The electrode is suitable for overlay and fusion welding of heat treatable steels alloyed with 17 % chromium. Often used as cover pass on tough austenitic filler passes (e.g in sulphurous media at elevated temperatures). Suitable for materials like: 1.4057, 1.4740, 1.4742, 1.4059, 1.4741.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mn	Fe
Min.		16	0,5	
Max.	0,1	18	1	Bal.

Mechanical properties:

(Heat treatment: 800°C/1h; Minimum values at ambient temperature)

Tensile strength R_m :	540	[MPa]
Yield strength $R_{p0.2}$:	340	[MPa]
Yield strength $R_{p1.0}$:	-	[MPa]
Elongation (L=5d):	20	[%]
Hardness:	150	[HB 30]
	240	[HB 30] without heat treatment

Positions: all except PD, PE and PG

Redrying: 320°C/2h

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

also available:
find in table of content

Capilla 4015 MAG
Capilla 4015 WIG
Capidur 4015