

Standards:

EN ISO 3581-A: EZ 13 1 B 42
 EN 1600: EZ 13 1 B 42
 AWS SFA-5.4: ~E 410 - 25
 Mat.-No.: 1.4018

Recovery: 150%

capilla® 4018

Product description:

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 is corrosion resistant as similar alloyed chromium steels.

It is recommended to preheat the work piece to approx. 250°C.

A stress-relief heat treatment at T_{PWHIT} up to 680°C is recommended.

Applications:

The electrode is suitable for overlay and fusion welding of heat treatable steels with 13 % Cr. Often used as filler material for cover passes on austenitic fusion weldings (e.g. in sulphurous media at higher temperatures).

Suitable for materials like:

1.4008.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Fe
Min.		11,5	1,5	
Max.	0,1	13,5	2	Bal.

Mechanical properties:

(Heat treatment: 640°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):	25	[%]
Hardness:	180 35	[HB 30] [HRC] 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 4018 MAG
 Capilla 4018 WIG
 Capilla G 4018 BM (tubular wire)