

Standards:		capilla® 4034
EN ISO 3581-A:	EZ 13	
EN 14700:	E Fe 7	
Mat.-No.:	1.4034	
Recovery:	150%	

Product description:	Applications:
Basic coated stick electrode for weld metal which is corrosion resistant as chromium steels of the same or similar kind. In case of welding unalloyed or low alloyed base metals preheating of the work piece is recommended (150°C - 350°C; depending on wall thickness). Base metals of the same or similar kind should be preheated in the range between 300 and 400°C.	The electrode is suitable for overlay and fusion welding of curable 13%-chromium steels. Overlay welding of gas, water and steam valves and fittings. Service temperatures up to 450°C. Furthermore suitable for heat and wear resistant overlays of rolls, drums and gripper tongs.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mn	Ni	Fe
Min.		12,5			
Max.	0,4	13,5	0,5	0,6	Bal.

Mechanical properties:

(Heat treatment: 550 - 760°C/ 2h; Minimum values at ambient temperature)

Hardness:	240 – 360	[HB 30
	51 – 55	[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	