

|                   |              |                      |
|-------------------|--------------|----------------------|
| <b>Standards:</b> |              | <b>capilla® 4115</b> |
| EN ISO 3581-A:    | EZ 17 1 B 42 |                      |
| EN 1600:          | EZ 17 1 B 42 |                      |
| Mat.-No.:         | 1.4115       |                      |
| <b>Recovery:</b>  | <b>150%</b>  |                      |

|                                                                                                                                                                                              |                                                                                                      |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------|
| <b>Product description:</b>                                                                                                                                                                  | <b>Applications:</b>                                                                                 |
| Basic coated high-recovery stick electrode suitable for welding of similar alloyed stainless chromium steels. Overlay welding of steam and gas fitting for service temperatures up to 450°C. | The electrode is perfectly suitable for overlay and fusion welding of 17 % chromium (nickel) steels. |
| Preheating: similar base metals: 300 – 400°C,<br>dissimilar base metals: 150 – 350°C.                                                                                                        | Suitable for materials like:<br><br>1.4313, 1.400, 1.4001, 1.4002.                                   |

### Typical weld metal composition:

[wt. - %]

|             | C           | Cr        | Ni         | Mo         | Mn         | Fe          |
|-------------|-------------|-----------|------------|------------|------------|-------------|
| <b>Min.</b> | <b>0,15</b> | <b>16</b> |            | <b>0,8</b> |            |             |
| <b>Max.</b> | <b>0,2</b>  | <b>17</b> | <b>0,5</b> | <b>1,2</b> | <b>0,7</b> | <b>Bal.</b> |

### Mechanical properties:

(Heat treatment: 720°C/8h; Minimum values at ambient temperature)

|                                    |     |                              |
|------------------------------------|-----|------------------------------|
| Tensile strength R <sub>m</sub> :  | 700 | [MPa]                        |
| Yield strength R <sub>p0,2</sub> : | 650 | [MPa]                        |
| Yield strength R <sub>p1,0</sub> : | -   | [MPa]                        |
| Elongation (L=5d):                 | 15  | [%]                          |
| Hardness:                          | 200 | [HB 30]                      |
|                                    | 43  | [HRC] without heat treatment |

Positions: all except PD; PE and PG

Redrying: 320°C/2h

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

**also available:**  
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Capilla 4115 MAG  
Capilla 4115 WIG  
Capidur 4115