

Standards:

EN ISO 3581-A: EZ 17 6 1 B 42
 EN 1600: EZ 17 6 1 B 42
 Mat.-No.: ~1.4405

capilla® 4405**Recovery: 150%****Product description:**

Basic coated high-recovery stick electrode suitable for welding of similar alloyed stainless ferritic-martensitic chromium steels. Overlay welding of steam and gas fitting for service temperatures up to 450°C.

The corrosion resistance of the weld metal is comparable with similar CrNi(Mo) steel grades and casts.

Preheating of thick walled base materials (s ≥ 10mm): 150 – 350°C

A PWHT is recommended.

Applications:

The electrode is perfectly suitable for overlay and fusion welding of 13 - 17 % Cr(Ni)- steels.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mo	Mn	Fe
Min.		16	5	0,8		
Max.	0,06	17	6	1,3	0,7	Bal.

Mechanical properties:

(Heat treatment: 600°C/8h; Minimum values at ambient temperature)

Tensile strength R _m :	800	[MPa]
Yield strength R _{p0,2} :	570	[MPa]
Yield strength R _{p1,0} :	-	[MPa]
Elongation (L=5d):	15	[%]
Impact strength (ISO-V):	35	[J]

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:

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Capilla G 4405 BM (tubular wire)