

Standards:

EN ISO 2560-A: E 42 0 RR 12
 (EN 499): E 42 0 RR 12
 AWS A 5.1: E 6013

capilla® 49**Approvals:****TÜV, DB****Product description:**

Thick rutile coated stick electrode usable in all position (except vertical down). Weld deposit is very smooth and slag is self-removing.

Applications:

For fusion welding of structural steels such as:

S 185 - S 355 JOC,
 P 235 GH, P 265 GH, P 295 GH,
 P 210 N - P 360 N,
 P 255 NH - P 355 NH,
 S 255 NH - S 355 NH,
 GS 38 - GS 52.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Fe
Min.				
Max.	0,08	0,6	0,45	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	510	[MPa]
Yield strength $R_{p0,2}$:	420	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	60	[J]

Positions:

All except PG

Redrying:

-

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,0	250	50 – 75
2,5	350	70 – 105
3,25	350/450	100 – 140
4,0	350/450	140 – 180
5,0	450	180 – 260

Polarity

=(-)~

also available:

find in table of content

Capilla 49 MAG
 Capilla 49 WIG
 Capilla G 460 MM (tubular wire)

Capilla G 460 PM (tubular wire)
 Capilla G 460 RM (tubular wire)
 Capilla G 460 BM (tubular wire)