

Standards:

EN 14700: E Fe 7-350-cpt
 EN ISO 3581-A: EZ 13 1 R 53
 (DIN 8555): E 6-UM-350-PRT

capilla® 4914**Recovery:****150%****Product description:**

Rutile coated high-recovery stick electrode for repair welding of hot-forming tools. The weld metal is characterised by its extraordinarily high crack resistance.

Applications:

The weld metal exhibits a combination of high tensile strength and toughness, thus allows crack-free overlays on rollers, cylinders and plier heads.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Fe
Min.		12,5	0,8	
Max.	0,25	14	1	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	1150	[MPa]
Yield strength $R_{p0,2}$:	650	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	15	[%]
Hardness:	37	[HRC]

Positions: all except PD, PE and PG

Redrying:

-

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	350	60 – 90	=(+)~
2,5	350	80 – 120	
3,25	350	100 – 160	
4,0	450	160 – 220	
5,0	450	190 – 260	

also available:

find in table of content

Capilla 4914 MAG

Capilla 4914 WIG