

Standards: EN ISO 2560-A: E 42 4 B 12 H10 (EN 499): E 42 4 B 12 H10 AWS A 5.1: E 7016 Approvals: TÜV, DB	capilla[®] 49 KBS
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Product description: Special (double coated) stick electrode suitable especially for crack-free welding at service temperatures in the range of -40°C up to 450°C in all positions; suitable as well on AC.	Applications: For fusion welding of C- and C-Mn-steels such as: S 185 - S 355 JOC, P 235 GH, P 265 GH, P 295 GH, P 120 N - P 360 N, P 255 NH - P 355 NH, GS 38 - GS 52.
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Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Fe
Min.				
Max.	0,06	0,9	0,7	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	550	[MPa]
Yield strength R _{p0.2} :	440	[MPa]
Yield strength R _{p1.0} :	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	80	[J]
	50 (-30°C)	[J]

Positions: all except PG

Redrying: 250 - 350°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	2,0	300	50 – 70	=(+)~
	2,5	350	70 – 90	
	3,25	350/450	115 – 135	
	4,0	450	150 – 175	
	5,0	450	190 – 240	

also available:
find in table of content

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

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