

Standards:

EN 14700: E Co 3
 (DIN 8555): E 20-UM-55 CTZ
 AWS: ~E Co Cr-C

capilla® 501 EHL

Recovery: 170%

Product description:

Synthetic high recovery stick electrode for overlays on sealing surfaces exposed to high pressure and elevated temperatures. The weld metal has excellent sliding properties on steels and a good cavitation resistance.

Applications:

Qualified for wear and heat resistant overlays on non-, low and high alloyed steels and steel cast which are heat-, rust- and acid-resisting. The weld metal stands out due to its very good coefficient of friction in case of metal to metal wear and its capability to be highly polished. The weld metal is scaling resistant.

Machining: grinding

Typical weld metal composition:

[wt. - %]

	C	Cr	W	Co
Min.	2,2	2,8	12	
Max.	2,6	32	14	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Hardness:	53 – 57	[HRC]
	43 – 47	[HRC] at 600°C

Positions: PA, PB

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,5	350	70 – 100	= (+) ~
3,25	350	100 – 140	
4,0	450	140 – 180	
5,0	450	180 – 220	

also available:
 find in table of content

Capilla 501 K
 Capilla 501 WIG

Capilla G 501 MM (tubular wire)
 Capidur 501