

Standards:

EN ISO 3581-A: E 18 8 Mn B 32
 EN 1600: E 18 8 Mn B 32
 AWS A 5.4: ~ E 307-15
 Mat.-No.: 1.4370

Approvals:

TÜV, DB

capilla® 51 KBN**Product description:**

Basic coated electrode for fusion welding of dissimilar steels and for cladding. The weld metal consists of austenitic Cr-Ni-Mn- steel for service temperatures of up to 300 °C.

Thin coated stick electrode especially suitable for repair welding of rails.

Applications:

Welding of dissimilar joints, fusion welding of high carbon steels and work hardening manganese steels e.g. X 120 Mn 12 (1.3401);

Fusion welding of "hard to weld" steels;

Buffer layers for hardfacing

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mn	Fe
Min.		17	7	5	
Max.	0,1	19	9	7	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	600	[MPa]
Yield strength R _{p0,2} :	350	[MPa]
Yield strength R _{p1,0} :	400	[MPa]
Elongation (L=5d):	40	[%]
Impact strength (ISO-V):	70	[J]

Positions: all except PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,5	300	60 – 90	= (+) ~
3,25	350	80 – 110	
4,0	350	100 – 150	
5,0	350/450	150 – 200	

also available:

find in table of content

Capilla 51 Ti
 Capilla 51 W
 Capilla 51 MAG

Capilla 51 WIG
 Capilla G 51 MM (tubular wire)
 Capicoat 51