Standards:

EN ISO 3581-A	E 18 8 MnMo R 12
EN 1600	EZ 18 8 MnMo R 12
AWS A 5.4:	~ E 307-16
Mat.-No.:	~1.4370

capilla® 51 Mo

Product description:

Rutile-basic coated stick electrode for fusion welding of dissimilar steels and for cladding.

The weld metal consists of austenitic Cr-Ni-Mn-Mo-steel for service temperatures of up to 300°C.

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	Mo	Fe
Min.		**19**	**8**	**4**	**0,5**	
Max.	**0,1**	**20**	**9**	**5**	**0,8**	**Rest**

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m:	700	[MPa]
Yield strength $R_{p0,2}$:	500	[MPa]
Yield strength $R_{p1,0}$:	400	[MPa]
Elongation (L=5d):	35	[%]
Impact strength (ISO-V):	70	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:

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

Polarity =(+)~

also available:
find in table of content

Capilla 51 KBN
Capilla 51 W
Capilla 51 MAG

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