

Standards:

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

capilla® 51 Ti**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-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	Fe
Min.	17	7	5	7	Bal.
Max.	0,1	19	9	7	

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: 300°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 KBN

Capilla 51 W

Capilla 51 MAG

Capilla 51 WIG

Capilla G 51 MM (tubular wire)

Capicoat 51