

Standards:

EN 14700: E Co 2
 (DIN 8555): E 20-UM-50 CTZ
 AWS: E Co Cr-B

capilla® 512 EHL

Recovery: 170%

Product description:

Synthetic high recovery stick electrode for overlays on working surfaces stressed by heavy impact and shock and simultaneously exposed to elevated temperatures. The weld metal has a good resistance against cavitation and erosion. Welded surfaces have good sliding properties (metal to metal) and are resistant to thermal shocks.

Microstructure: Cr- and W-carbides
 embedded in austenitic Co-
 base matrix

Applications:

For overlays on sealing surfaces of steam-, gas-, water- and acid-fittings, valve seats of combustion engines.

Also suitable for hardfacing of edges of billet shears, hot extruder nozzles, sawteeth (wood processing) etc.

Typical weld metal composition:

[wt. - %]

	C	Cr	W	Co
Min.	1,2	26	9	
Max.	1,4	30	11	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Hardness:	46 – 58	[HRC]
	36 – 42	[HRC] at 600°C

Positions: PA, PB

Redrying: 300 - 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,5	350	70 – 110	= (+) ~
3,25	350	100 – 140	
4,0	450	140 – 180	
5,0	450	180 – 220	

also available:
 find in table of content

Capilla 512 K
 Capilla 512 WIG

Capilla G 512 MM (tubular wire)
 Capidur 512