Standards:

EN 14700: E Co 2-55-cstz
(DIN 8555): E 20-UM-50 CTZ
AWS: E Co Cr-B

Recovery: **130%**

capilla® 512 K

Product description:

Core wire alloyed 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, PC

Redrying: 300 – 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	350	70 – 100
3,25	350	90 – 120
4,0	350	120 - 155
5,0	350	150 - 190

Polarity =(+)~

also available:
find in table of content

Capilla 512 EHL
Capilla 512 WIG

Capilla G 512 MM (tubular wire)
Capidur 512