

Standards:

EN 14700: E Co 1
(DIN 8555): E 20-UM-250 CKTZ

capilla® 516 EHL

Recovery: 170%

Product description:

High recovery stick electrode suitable for welding of wear resistant and corrosion resistant overlay clads on un-, low and high alloyed steels and steel casts. Due to the very good coefficient of friction (metal to metal) the deposits show an outstanding resistance to sliding wear.

The weld metal has no susceptibility to cracks. The wear resistance of the cladding can be improved by strain hardening.

Max.service temperatures:

Long term duty: up to 800 °C.

Short term duty: up to 1100 °C.

Applications:

Highly heat resistant special alloy for platings which are exposed to thermal shock and impact e.g. cladding of hot working tools such as dies, punches and hot deburring tools.

If attention is paid to the strain hardening characteristic of the alloy, machining by chipping technology is feasible.

Typical weld metal composition:

[wt. - %]

	C	Cr	W	Ni	Fe	Co
Min.		17	11	8	1,5	
Max.	0,1	19	13	10	3	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Hardness:	240	[HB]
	>300	[HB] workhardened

Positions: PA, PB

Redrying: 300 - 320°C/2h

Dimension:

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

also available:
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Capilla G 516 MM (tubular wire)
Capdur 516