Standards:

EN ISO 3581-A: EZ 29 9 3 R 32
EN 1600: EZ 29 9 3 R 32

capilla® 52 K Mo

Product description:

Rutile-basic coated stick electrode for joint welding of dissimilar steels;
very good suitability for buffer layers and overlay weldings;
The electrode produces a very soft arc and self-removing slags, easy to weld without any splatters.
The weld metal has a ferritic-austenitic microstructure (high strength duplex stainless steel).

Very good mechanical properties and corrosion resistance even in comparison to Capilla 52 K.

Applications:

Corrosion resistant like similar alloyed steel and steel cast e.g.

1.4762 (X 10 CrAl 24),
1.4085 (G-X 70 Cr 29).

Suitable for difficult to weld steels, e.g. constructional steel with high tensile strength, fusion welding of high alloyed manganese steels and joints of this steels with high-alloyed steel, suitable for repair and maintenance;
Very corrosion resistant claddings on mild steel.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mo	Fe
Min.		**27,5**	**8**	**2,5**	
Max.	**0,1**	**30**	**10**	**3,5**	**Bal.**

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m:	780	[MPa]
Yield strength $R_{p0,2}$:	550	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	18	[%]
Impact strength (ISO-V):	40	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
1,6	250	30 – 50
2,0	250	40 – 60
2,5	300	60 – 90
3,25	350	80 – 110
4,0	350	100 – 150
5,0	350	150 – 200

Polarity
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