Standards:

EN ISO 3581-A:	E 29 9 R 12
EN 1600:	E 29 9 R 12
AWS A 5.4:	E 312-16
Mat.-No.:	1.4337
Approvals:	**DB**

capilla® 52 K

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).

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, cladding of rail steels, fusion welding of high alloyed manganese steels and joints of this steels with high-alloyed steel, suitable for repair and maintenance.

Typical weld metal composition:

[wt. - %]

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

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m:	750	[MPa]
Yield strength $R_{p0,2}$:	500	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	20	[%]
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 =(+)~

also available:
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Capilla 52
Capilla 52 MAG
Capilla 52 WIG