

Standards:

EN 14700: E Ni 2-200-ckptz
 (DIN 8555): E 23-UM-200-CKPTZ
 AWS A 5.11: E NiCrMo 4
 Mat.-No.: ~2.4887

Recovery: 170%

capilla® 5200 S

Product description:

Rutile-basic coated stick electrode for overlay welding on hot forming tools. The deposited metal exhibits good scaling resistance and good strength at elevated temperatures.

Furthermore, corrosion resistant at high temperatures in oxidizing and reducing media.

Applications:

Overlays on dies, hot shearing tools, punching tools and all tools used for high temperature applications. Furthermore, suitable for welding of corrosion resistant claddings of vessels and equipment used in the chemical industry

Typical weld metal composition:

[wt. - %]

	C	Cr	Mo	W	Fe	V	Ni
Min.		14	15	3	5		
Max.	0,06	17	17	5	6	0,6	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	700	[MPa]
Yield strength R _{p0.2} :	400	[MPa]
Yield strength R _{p1.0} :	-	[MPa]
Elongation (L=5d):	25	[%]
Hardness:	250	[HB]
	>400	[HB] workhardened

Positions: PA, PB

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,0	350	40 – 70
2,5	350	60 – 90
3,25	350	80 – 110
4,0	450	100 – 150
5,0	450	150 – 200

Polarity

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also available:

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Capilla 5200 MAG
 Capilla 5200 WIG
 Capilla G 5200 MM (tubular wire)

Capicoat 5200 S