

Standards:		capilla® 5200
EN 14700:	E Ni 2-200-ckptz	
(DIN 8555):	E 23-UM-200-CKPTZ	
AWS A 5.11:	~E NiCrMo 4	
Mat.-No.:	c2.4887	
Recovery:	170%	

Product description:	Applications:
Overlay welding on hot forming tools. The deposited metal shows good scaling resistance and good strength at elevated temperatures. Furthermore, corrosion resistant in oxidizing and reducing media.	Overlays on dies, hot shearing tools, punching tools and all tools used for high temperature applications.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mo	W	Fe	Co	Ni
Min.		15	15	3	5	2,5	
Max.	0,06	17	17	5	6	3,5	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:	220	[HB]
	>400	[HB] workhardened

Positions: PA; PB

Redrying: 320°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	2,0	350	40 – 60	= (+) ~
	2,5	350	60 – 90	
	3,25	350	80 – 110	
	4,0	450	100 – 150	
	5,0	450	150 – 200	