Standards:

EN 14700:	E Co 1
(DIN 8555):	E 20-UM-300 CTZ
AWS:	E CoCr-E
Recovery:	**130%**

capilla® 521 K

Product description:

Core wire alloyed stick electrode for the hardfacing of unalloyed, low alloyed and high alloyed steels. The weld metal is heat resistant and shows a good resistance to corrosive media.
In the case of friction and sliding wear the alloy has a low friction coefficient to steels.

Max. service temperatures: 800°C.

Applications:

High heat resistant special alloy with good high temperature strength. The weld metal shows an excellent resistance to mechanical shock.
This electrode is standardly used for the hardfacing of forging dies, punches and hot cutting tools. Furthermore suitable for the cladding of sealing surface of valves used in power plants and chemical industry

Typical weld metal composition:

[wt. - %]

	C	Cr	Mo	Ni	Co
Min.	**0,15**	**30**	**4,5**	**3**	
Max.	**0,3**	**33**	**5,5**	**4**	**Bal.**

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Hardness:	27 – 31	[HRC]

Positions: PA, PB, PC

Redrying: 300 – 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	350	70 – 100
3,25	350	90 – 120
4,0	350	120 - 155
5,0	350	150 - 190

Polarity =(+)~

also available:
find in table of content

Capilla 521 EHL
Capilla 521 WIG

Capilla G 521 MM (tubular wire)
Capidur 521