

**Standards:**

EN 14700: E Co 1  
(DIN 8555): E 20-UM-350 CTZ

**capilla® 523 EHL**

**Recovery:** 170%

**Product description:**

High recovery stick electrode for the hardfacing of non-alloyed, low alloyed and high alloyed steels. The weld metal is heat resistant and shows a good resistance against corrosive media. In the case of friction and sliding wear the alloy has a low friction coefficient against steels. Service temperatures up to 800°C.

Slightly harder than Capilla 521

**Applications:**

High heat resistant special alloy with good high temperature strength. The weld metal shows an excellent resistance to mechanical shock. This electrode is used for 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 | Nb | W | Fe | Co   |
|------|-----|----|-----|----|----|---|----|------|
| Min. | 0,3 | 24 | 4,5 | 5  | 6  | 2 |    |      |
| Max. | 0,4 | 26 | 5,5 | 6  | 7  | 3 | 3  | Bal. |

**Mechanical properties:**

(without heat treatment; minimum values at ambient temperature)

Hardness: 35 – 37 [HRC]

Positions: PA, PB

Redrying: 300 – 320°C/2h

**Dimension:**

| Ø [mm] | Length [mm] | Welding current [A] |
|--------|-------------|---------------------|
| 2,5    | 350         | 70 – 110            |
| 3,25   | 350         | 100 – 140           |
| 4,0    | 450         | 140 – 180           |
| 5,0    | 450         | 180 – 220           |

**Polarity**  
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