

Standards:		capilla® 526
EN14700:	E Ni 2-200-ckptz	
(DIN 8555):	E 23-UM-250 CKPTZ	
EN ISO 14172:	E Ni 6625 (NiCr22Mo9Nb)	
AWS A5.11:	E NiCrMo 3	
Mat.-No.:	2.4621	
Recovery:	170%	

Product description:	Applications:
Thick coated special stick electrode for repair and maintenance of highly temperature resistant hot working tools which are heavy loaded by impact and thermal shock.	Stick electrode suitable for hardfacing of hot shearing tools, hot deburring tools, punches, hot extrusion dies etc.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mo	Nb	Fe	Ni
Min.		20	8	3	2,5	
Max.	0,06	22	10	4	3,5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	750	[MPa]
Yield strength $R_{p0,2}$:	480	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	35	[%]
Impact strength (ISO-V):	70	[J]

Positions: PA, PB

Redrying: 320°C/2h

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

also available:
find in table of content

Capilla 526 MAG
Capilla 526 WIG