

Standards:

EN 14700: E Fe 4-60-stp
 (DIN 8555): E 4-UM-60-ST
 Mat.-No.: 1.3346

capilla® 53**Recovery: 140%****Product description:**

Very thick basic coated high-recovery stick electrode for overlay welding of tool and high-speed steels.

The weld metal is resistant against abrasion, impact, pressure and temperatures up to 550°C.

Applications:

Stick electrode for the hardfacing of cutting tools, such as hot block and billet shears, coal cutting devices (mining industry), cutting, punching, forging, pressing and drawing tools.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mo	V	W	Fe
Min.	0,8	4	7	1,2	1,5	
Max.	1	5	9	1,8	2,5	Bal.

Mechanical properties:

(Minimum values at ambient temperature)

Hardness:	58 - 62	[HRC] as welded
	63 - 65	[HRC] annealed (530°C)
	250	[HB] soft annealed (810°C)
	60 - 63	[HRC] hardened 1220°C

Positions: all except PD, PE and PG

Redrying: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	350	80 – 120
3,25	350	100 – 160
4,0	450	160 – 220
5,0	450	190 – 260

Polarity
=(+)~**also available:**Capilla 53 Ti
Capilla 53 MAG

Capilla 53 WIG