

|                   |               |                      |
|-------------------|---------------|----------------------|
| <b>Standards:</b> |               | <b>capilla® 5400</b> |
| EN 14700:         | E Fe 8-60-gpt |                      |
| (DIN 8555):       | E 6-UM-60     |                      |
| <b>Recovery:</b>  | <b>130%</b>   |                      |

|                                                                                                                                                                                                                                                           |                                                                                                                                           |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Product description:</b>                                                                                                                                                                                                                               | <b>Applications:</b>                                                                                                                      |
| Basic coated Cr-Mo-V alloyed stick electrode for extremely hard overlay welding on constructional components and machine parts, which are exposed to high levels of frictional wear and heavy impacts. Hardfacing of components of earth moving machines. | Production of new tools and repair of worn out tools and machine parts such as rolls, baffle plates, forging, pressing and drawing tools. |

### Typical weld metal composition:

[wt. - %]

|             | <b>C</b>   | <b>Cr</b> | <b>Mo</b>  | <b>V</b>   | <b>Fe</b>   |
|-------------|------------|-----------|------------|------------|-------------|
| <b>Min.</b> | <b>0,8</b> | <b>9</b>  | <b>1,5</b> | <b>1</b>   |             |
| <b>Max.</b> | <b>1</b>   | <b>10</b> | <b>2,5</b> | <b>1,5</b> | <b>Bal.</b> |

### Mechanical properties:

(Minimum values at ambient temperature)

|           |         |                       |
|-----------|---------|-----------------------|
| Hardness: | 57 – 60 | [HRC] as welded       |
|           | 30 – 40 | [HRC] 500°C           |
|           | 56 – 59 | [HRC] hardened 1050°C |

Positions: all except PD, PE and PG

Redrying: 320°C/2h

|                   |               |                    |                            |                            |
|-------------------|---------------|--------------------|----------------------------|----------------------------|
| <b>Dimension:</b> | <b>Ø [mm]</b> | <b>Length [mm]</b> | <b>Welding current [A]</b> | <b>Polarity</b><br>= (+) ~ |
|                   | 2,5           | 350                | 60 – 90                    |                            |
|                   | 3,25          | 350                | 95 – 150                   |                            |
|                   | 4,0           | 450                | 140 – 190                  |                            |
|                   | 5,0           | 450                | 190 – 250                  |                            |

**also available:**  
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Capilla 5400 MAG  
Capilla 5400 WIG

Capilla G 5400 MM (tubular wire)