

**Standards:**EN 14700  
(DIN 8555):E Fe 1-300-p  
E 3-UM-300 GP**capilla® 64 KB****Recovery:****130%****Product description:**

Basic-coated high-recovery stick electrode for high-strength, heat treatable joint and overlay welding. The weld metal exhibits good crack resistance and is resistant against compressive and impact stress.

**Applications:**

The electrode is used for repair and maintenance work on dies, rails, crane rims, feeder rollers.

**Base Materials:**

Mild steels, tool steels, heat treatable steels (TS up to 1200 MPa), high-temperature structural steels.

**Typical weld metal composition:**

[wt. - %]

|             | C           | Cr         | Si         | Mo         | Fe          |
|-------------|-------------|------------|------------|------------|-------------|
| <b>Min.</b> | <b>0,06</b> | <b>2</b>   |            | <b>0,8</b> |             |
| <b>Max.</b> | <b>0,1</b>  | <b>2,5</b> | <b>0,5</b> | <b>1</b>   | <b>Bal.</b> |

**Mechanical properties:**

(without heat treatment; minimum values at ambient temperature)

|                             |      |       |
|-----------------------------|------|-------|
| Tensile strength $R_m$ :    | 1000 | [MPa] |
| Yield strength $R_{p0,2}$ : | 650  | [MPa] |
| Yield strength $R_{p1,0}$ : | -    | [MPa] |
| Elongation (L=5d):          | 19   | [%]   |
| Hardness:                   | 290  | [HB]  |

Positions:

all except PD, PE and PG

Redrying:

300 - 330°C/2h

**Dimension:**

| Ø [mm] | Length [mm] | Welding current [A] |
|--------|-------------|---------------------|
| 2,5    | 350         | 60 – 90             |
| 3,25   | 350         | 95 – 150            |
| 4,0    | 450         | 140 – 190           |
| 5,0    | 450         | 190 – 250           |
| 6,0    | 450         | 220 – 290           |

**Polarity**

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**also available:**

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Capilla 64 MAG  
Capilla 64 WIG

Capilla G 64 MM (tubular wire)