

Standards: EN 14700 (DIN 8555):		E Fe 3-350-st E 3-UM-350 GP	capilla® 64 KBS
Recovery:		130%	

Product description: Basic-coated high recovery stick electrode for high-strength, heat treatable fusion and overlay welding. Also suitable as filler for difficult to weld steels. The weld metal is characterized by its high crack resistance and is extremely resistant against compressive and impact stress.	Applications: The electrode is used for repair and maintenance welding of all kinds of medium alloyed steels especially constructional and tool steels. Suitable for repair and manufacturing welding of dies, rails, crane rims, support rollers, various machine parts.
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Typical weld metal composition:

[wt. - %]

	C	Cr	Si	Mo	Mn	Fe
Min.		2,2		2		
Max.	0,1	2,7	0,5	2,5	1	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	1200	[MPa]
Yield strength R _{p0,2} :	810	[MPa]
Yield strength R _{p1,0} :	-	[MPa]
Elongation (L=5d):	-	[%]
Hardness:	350	[HB]

Positions: all except PD, PE and PG

Redrying: 300 - 330°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	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	

also available: Capilla G 105 MM (tubular wire)
find in table of content