

|                   |              |                       |
|-------------------|--------------|-----------------------|
| <b>Standards:</b> |              | <b>capilla® 65 Ti</b> |
| EN 14700:         | E Fe 3-45-st |                       |
| (DIN 8555):       | E 3-UM-45-T  |                       |
| Mat.-No.:         | ~1.2567      |                       |
| <b>Recovery:</b>  | <b>130%</b>  |                       |

|                                                                                                                                                                                                                                                                   |                                                                                                                                                                       |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Product description:</b>                                                                                                                                                                                                                                       | <b>Applications:</b>                                                                                                                                                  |
| <p>Rutile coated universal stick electrode for heat-resistant, tough repair welding of hot-forming tools having similar alloying composition and properties. The weld metal exhibits good resistance to thermal shocks.</p> <p>Service temperature max. 550°C</p> | <p>Repair and manufacturing welding of tools which are exposed to wear at elevated temperatures such as:</p> <p>dies, punches, hot shearing tools, swaging tools.</p> |

### Typical weld metal composition:

[wt. - %]

|      | C   | Cr  | Mn  | W | V   | Si  | Fe   |
|------|-----|-----|-----|---|-----|-----|------|
| Min. | 0,1 | 2,2 | 1   | 4 | 0,4 |     |      |
| Max. | 0,3 | 2,8 | 1,2 | 5 | 0,8 | 0,6 | Bal. |

### Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

|           |         |                                |
|-----------|---------|--------------------------------|
| Hardness: | 41 - 45 | [HRC] as welded                |
|           | 45 - 50 | [HRC] annealed(550°C/2h)       |
|           | 20 - 25 | [HRC] soft annealed (ca.800°C) |

Positions: all except PE and PG

Redrying: 300 - 320°C/2h

| Dimension: | Ø [mm] | Length [mm] | Welding current [A] | Polarity<br>=(+)~ |
|------------|--------|-------------|---------------------|-------------------|
|            | 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:**  
find in table of content

Capilla 65  
Capilla 65 MAG

Capilla 65 WIG  
Capilla G 65 MM (tubular wire)