

Standards:

EN 14700: E Fe 3-45-st
 (DIN 8555): E 3-UM-45-T
 Mat.-No.: ~1.2567

capilla® 65**Recovery:** 130%**Product description:**

Basic 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.
 Service temperature max. 550°C.

Applications:

Repair and manufacturing welding of tools which are exposed to wear at elevated temperatures such as:

dies, punches, hot shearing tools, swaging tools.

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:

(Minimum values at ambient temperature)

Hardness:	41 - 45 45 - 50 20 - 25	[HRC] as welded [HRC] annealed(550°C/2h) [HRC] soft annealed (ca.800°C)
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Positions: all except 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:
 find in table of content

Capilla 65 Ti
 Capilla 65 MAG

Capilla 65 WIG
 Capilla G 65 MM (tubular wire)