

Standards:

EN 14700: E Fe 3-55-st
(DIN 8555): E 6-UM-50-PST
Mat.-No.: 1.2344

capilla® 6500**Recovery: 130%****Product description:**

Basic coated stick electrode for hardfacing and repair welding of tool steels such as 1.2307-1.2377.

The surfaces of the tool to be welded must be cleaned carefully. All cracks have to be removed before welding.

Applications:

Overlays of similar alloyed hot forming tool steels and hardfacing of tools made of low alloyed steels. Before welding, tool steels need to be preheated to 300 - 500°C (max.: tempering temperature of base material). Low alloyed steels should be preheated up to 200 - 300°C. Cooling should be carried out slowly in the furnace. To improve the toughness of the weld metal, a post weld heat treatment is recommended.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mo	V	Fe
Min.	0,4	5	1,2	0,8	
Max.	0,6	6,5	1,8	1,2	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Hardness:	approx.. 55	[HRC] as welded
	52 – 55	[HRC] annealed(550°C/2-8h)
	42 – 48	[HRC] annealed(650°C/2-8h)

Positions: all except PD, PE and PG

Redrying: 300 - 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	350	80 – 110
3,25	350	90 – 150
4,0	450	160 – 220
5,0	450	190 – 260
6,0	450	220 – 290

Polarity
=(+)~**also available:**

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Capilla 6500 Ti
Capilla 6500 MAGCapilla 6500 WIG
Capilla G 6500 MM (tubular wire)