

**Standards:**

EN 14700: E Fe 3-55-st  
(DIN 8555): E 3-UM-55-T

**capilla® 66**

**Recovery:** 140%

**Product description:**

Rutile-basic coated high-recovery stick electrode for overlay welding on heat resistant forming tools. The weld metal is extremely resistant to abrasion, impact and pressure.

**Applications:**

This electrode is used for repair welding of hot-forming tools such as dies. Also qualified for new production (contour changes) of dies, as well as hardfacing of cold shearing tools.

**Typical weld metal composition:**

[wt. - %]

|      | C   | Cr | Ni  | Mo  | W | V   | Fe   |
|------|-----|----|-----|-----|---|-----|------|
| Min. |     | 6  | 0,4 | 1   | 6 | 0,5 |      |
| Max. | 0,4 | 8  | 0,7 | 1,5 | 8 | 0,8 | Bal. |

**Mechanical properties:**

(without heat treatment; minimum values at ambient temperature)

|           |         |                            |
|-----------|---------|----------------------------|
| Hardness: | 50 – 55 | [HRC] as welded            |
|           | 53 – 56 | [HRC] annealed(550°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 – 120            |
| 3,25   | 350         | 100 – 160           |
| 4,0    | 450         | 160 – 220           |
| 5,0    | 450         | 190 – 260           |
| 6,0    | 450         | 220 – 290           |

**Polarity**  
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