

Standards:		capilla® 733
EN 14700:	E Fe 3-50-st	
(DIN 8555):	E 3-UM-50-ST	
Recovery:	130%	

Product description:	Applications:
Basic coated stick electrode for welding of heat resistant overlays on hot work tool steels. Due to a good combination of toughness and hardness, the weld metal exhibits good resistance against pressure, abrasion and cracks.	For overlays on cutting edges of hot shearing tools, plier heads, cutting edges of deburring tools, punching tools, continuous cast rollers. Hardfacing of cylinders and rolls of plate levelling devices. Furthermore suitable for the repair welding and new production of hot work tools. Service temperatures: max. 550°C.
	In order to improve the toughness of weld metal and heat affected zone of the base material, a post weld heat treatment is recommended.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mn	Mo	Ti	Si	Fe
Min.		4		3,0			
Max.	0,25	6	0,7	4,0	+	1,0	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Hardness:	45 – 50	[HRC]
-----------	---------	-------

Positions: all except PD, PE and PG

Redrying: 300 - 320°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity =(+)~
	2,5	350	80 – 120	
	3,25	350	100 – 160	
	4,0	450	160 – 220	
	5,0	450	190 – 260	

also available:
find in table of content

Capilla 733 MAG
Capilla 733 WIG