

Standards:EN 14700:
(DIN 8555):E Fe 3-40-st
E 3-UM-40-PT**capilla® 734****Recovery:****130%****Product description:**

Basic coated stick electrode suitable for welding of heat resistant overlays on hot forming tools. Good resistance against shock, pressure and abrasive wear. The weld metal exhibits medium hardness and is not susceptible to cracks.

Applications:

For overlays on forging dies, die casting tools, continuous cast rollers, rolls, fences of tools and machines;

New production and repair of hot forming tools;

Service temperatures: max. 550°C.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mn	Mo	Si	Fe
Min.		6		3		
Max.	0,1	7	0,6	3,5	0,4	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Hardness: 38 – 42 [HRC]

Positions: all except PD, PE and PG

Redrying: 300 - 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	350	60 – 90
3,25	350	95 – 150
4,0	450	140 – 190
5,0	450	190 – 250

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

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Capilla 734 MAG

Capilla 734 WIG