

Standards: EN 14700: not classified (DIN 8555): special alloy		capilla® 93
Recovery:	170%	

Product description: Rutile-basic coated stick electrode for overlay welding. The weld metal is not susceptible to cracks. Even in the first layer good hardness can be realised. The weld metal exhibits high resistance to metal/metal friction, cavitation, corrosion and fatigue wear and provides an extremely high level of oxidation resistance when exposed to high temperatures.	Applications: For partial or complete overlays on forging dies, die stamps, tools for hot forming in general, high-temperature pumps, rollers for continuous casting facilities, etc.
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Typical weld metal composition:

[wt. - %]

	C	Cr	Co	Mo	Fe
Min.		15	13	2,2	
Max.	0,15	16	14	2,8	Bal.

Mechanical properties:

(Minimum values at ambient temperature)

Hardness:	42 – 48	[HRC] As welded
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Positions: PA, PB, (PC)

Redrying: 300°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: Capilla G 93 MM
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