

Standards:		capilla® P 121
EN ISO 3580-A:	E CrMoWV 12 B 42	
EN 1599:	E CrMoWV 12 B 42	
Mat.-No.:	1.4937	
Recovery:	130%	

Product description:	Applications:
CrMoNiWV-alloyed basic coated stick electrode, good welding characteristics producing a creep and rupture resistant high temperature weld metal matching similar alloyed base metals	Welding of similar high temperature 12%-Cr-steels and steel casts (quenched and tempered)
	Base materials:
	1.4913 (X19CrMoVNb 11-1),
	1.4922 (X20CrMoV 12-1),
	1.4923 (X22CrMoV 12-1),
	1.4935 (X20CrMoWV 12-1),
	1.4931 (GX22CrMoV 12-1).

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Cr	Mo	Ni	V	W	Fe
Min.		0,5		10,5	0,9	0,5	0,18	0,5	
Max.	0,03	0,6	0,4	11,5	1,1	0,6	0,24	0,6	Bal.

Mechanical properties:

(Heat treatment: 760°C/2h; Minimum values at ambient temperature)

Tensile strength R _m :	700	[MPa]
Yield strength R _{p0.2} :	590	[MPa]
Yield strength R _{p1.0} :	-	[MPa]
Elongation (L=5d):	15	[%]
Impact strength (ISO-V):	35	[J]

Positions: all except PD, PE and PG

Redrying: min. 320°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	2,5	350	60 – 90	=(+)
	3,25	350	80 – 110	
	4,0	350	100 – 150	