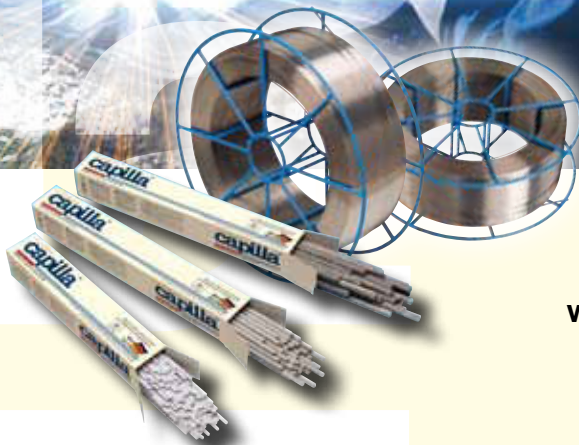


capilla®

Part catalogue



**1. Welding
consumables for
welding of structural
and constructional
steels**

1 Welding consumables for welding of structural and constructional steels

1.1 Coated stick electrodes for welding of structural and constructional steels

capilla®	DIN EN ISO 2560-A DIN EN ISO 3580-A*	(EN 499) (EN 1599)*	AWS A 5.1 AWS A 5.5*	Page
30 S	E 42 0 RC 11	E 42 0 RC 11	E 6013	9
30 W	E 38 2 RB 12	E 38 2 RB 12	E 6013	10
30-170	E 42 0 RR 53	E 42 0 RR 53	E 7024-1	11
49	E 42 0 RR 12	E 42 0 RR 12	E 6013	12
49 KBS	E 42 4 B 12 H10	E 42 4 B 12 H10	E 7016	13
KB Mo	E Mo B 22*	E Mo B 22*	E 7018-A1*	14
CrMo B	E Cr Mo 1 B 42*	E Cr Mo 1 B 42*	E 8018-B2*	15
CrMo 1Ti	E Cr Mo 1 R 42*	E Cr Mo 1 R 42*	~E 8018-B2*	16
CrMo 2 B	E Cr Mo 2 B 42*	E Cr Mo 2 B 42*	~E 9018-B3*	17
CrMoV 3	EZ CrMo 3 V B 42*	E CrMo 3 V B 42*	-	18
CrMo 5 B	E CrMo 5 B 42*	E CrMo 5 B 42*	E 8015-B6*	19

1.2 Wire electrodes for welding of structural and constructional steels

1.2.1 Solid wires for gas shielded arc welding of structural and constructional steels

capilla®	EN ISO 14341-A EN ISO 21952-A* EN ISO 16834-A**	AWS A5.18 AWS A5.28*	Page
30 MAG	G3Si1	ER 70S-6	20
49 MAG	G4Si1	ER 70S-6	20
SG Mo MAG	G Mo Si*	ER 80S-6	20
SG CrMo 1 MAG	G CrMo 1 Si*	ER 80S-6	20
SG CrMo 2 MAG	G CrMo 2 Si*	ER 90S-6	20
SG CrMo 5 MAG	G CrMo 5 Si*	-	20
SG Ni Mo MAG	-	ER90S-G*	20
SG NiMoCr MAG	-	ER100S-G*	20
690 F MAG	G 69 6 M Mn4Ni1,5CrMo **		20

1.2.2 Welding rods for tungsten inert gas welding of structural and constructional steels

capilla®	EN ISO 636-A EN ISO 21952-A*	AWS A5.18 AWS A5.28*	Page
30 WIG	W 42 5 W3Si1	ER 70S-6	21
49 WIG	W 46 4 W4Si1	ER 70S-6	21
SG Mo WIG	W Mo Si*	ER 80S-6	21
SG Ni Mo WIG	-	ER 90S-G*	21
SG CrMo 1 WIG	W CrMo 1 Si*	ER 80S-6	21
SG CrMo 2 WIG	W CrMo 2 Si*	ER 90S-6	21
SG CrMo 5 WIG	W CrMo 5 Si*	-	21
SG NiMoCr WIG	-	ER 100S-G*	21
690 F WIG	W 69 6 M Mn4Ni1,5CrMo **	-	21

1.2.3 Tubular wires for gas shielded arc welding of structural and constructional steels

capilla®	EN ISO 17632-A	AWS A5.20	Page
30 K RLD	T 38 Z W 3	E 70T-4	21
G 460 MM	T 46 2 MM 2	E 71T-6M	21
G 460 BM	T 46 6 BM 1	E 71T-5M	21
G 460 PM	T 46 4 PM 1	E 71T-1M	21
G 690 BM	T 69 5 Mn2NiCrMo BM 3	E 110T5-K4	21

Standards:

DIN EN ISO 2560-A: E 42 0 RC 11
 (EN 499): E 42 0 RC 11
 AWS SFA-5.1: E 6013

capilla® 30 S**Approvals:**

TUV, DB

Product description:

Medium-thick rutile-cellulose coated stick electrode for assembly and maintenance welding in all positions, especially suitable for vertical down welding. Good bridging over of gaps. Using recommended welding parameters leads to self-removing slag.

Applications:

Fusion welding of general purpose constructional steel, boiler plates, pipe steel, ship structural steel, high tensile steel and cast steel such as:

S 185 - S 355 JOC,
 P 235 GH, P 265 GH, P 295 GH,
 P 210 N - P 360 N,
 S 255 NH - S 355 NH,
 P 255 NH - P 355 NH,
 GS 38 - GS 52.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Fe
Min.				
Max.	0,08	0,5	0,3	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	510	[MPa]
Yield strength $R_{p0.2}$:	380	[MPa]
Yield strength $R_{p1.0}$:	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	50	[J]

Positions: all

Redrying: -

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	250	50 – 60	=(-)~
2,5	350	60 – 85	
3,25	350	90 – 130	
4,0	350	140 – 180	
5,0	350	180 – 240	

also available:

find in table of content

Capilla 30 MAG
 Capilla 30 WIG
 Capilla 30 K RLD (tubular wire)

Standards:

DIN EN ISO 2560-A: E 38 2 RB 12
 (EN 499): E 38 2 RB 12
 AWS SFA-5.1: E 6013

capilla® 30 W

Product description:

Rutile-basic coated stick electrode especially suitable for welding of pipe roots as well as in pipeline and boiler construction in constrained position. Due to the low Si-content of the weld metal the weld seams can be galvanised without any problems.

Applications:

Fusion welding of general purpose constructional steel, boiler plates, pipe steel, ship structural steel, high tensile steel and cast steel such as:

S 185 - S 355 JOC,
 P 235 GH, P 265 GH, P 295 GH,
 P 210 N - P 360 N,
 S 255 NH - S 355 NH,
 P 255 NH - P 355 NH,
 GS 38 - GS 52

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Fe
Min.				
Max.	0,08	0,5	0,3	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	520	[MPa]
Yield strength $R_{p0,2}$:	400	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	80	[J]

Positions: all

Redrying: -

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	300	60 – 85
3,25	350	90 – 130
4,0	350	140 – 180
5,0	450	180 – 240

Polarity
 =(-)~

also available:
 find in table of content

Capilla 30 MAG
 Capilla 30 WIG
 Capilla 30 K RLD (tubular wire)

Standards:

EN ISO 2560-A: E 42 0 RR 53
 (EN 499): E 42 0 RR 53
 (DIN 1913): E 51 22 RR 11 160
 AWS A 5.1: E 7024-1

capilla[®] 30-170**Recovery:** 165%**Product description:**

Rutile coated stick electrode with very high recovery. The high deposition rate of this consumable grant economical welding of fillets. Concave shape of fillet welds. Good bridging over of gaps. The slag is easy to remove.

Applications:

Fusion welding of general purpose constructional steel, boiler plates, pipe steel, ship structural steel, high tensile steel and cast steel such as:

S 185 - S 355 JOC,
 P 235 GH, P 265 GH, P 295 GH,
 P 210 N - P 360 N,
 S 255 NH - S 355 NH,
 P 255 NH - P 355 NH,
 GS 38 - GS 52.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Fe
Min.				
Max.	0,08	0,6	0,3	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	520	[MPa]
Yield strength $R_{p0.2}$:	420	[MPa]
Yield strength $R_{p1.0}$:	-	[MPa]
Elongation (L=5d):	22	[%]
Impact strength (ISO-V):	80	[J]

Positions: PA, PB, PC

Redrying: -

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
3,25	350	90 – 130	=(-)~
4,0	350	140 – 180	
5,0	450	180 – 240	

also available:
 find in table of content

Capilla 30 MAG
 Capilla 30 WIG
 Capilla 30 K RLD (tubular wire)

Standards:

EN ISO 2560-A: E 42 0 RR 12
 (EN 499): E 42 0 RR 12
 AWS A 5.1: E 6013

capilla® 49**Approvals:**

TÜV, DB

Product description:

Thick rutile coated stick electrode usable in all position (except vertical down). Weld deposit is very smooth and slag is self-removing.

Applications:

For fusion welding of structural steels such as:

S 185 - S 355 JOC,
 P 235 GH, P 265 GH, P 295 GH,
 P 210 N - P 360 N,
 P 255 NH - P 355 NH,
 S 255 NH - S 355 NH,
 GS 38 - GS 52.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Fe
Min.				
Max.	0,08	0,6	0,45	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	510	[MPa]
Yield strength $R_{p0,2}$:	420	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	60	[J]

Positions: All except PG

Redrying: -

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,0	250	50 – 75
2,5	350	70 – 105
3,25	350/450	100 – 140
4,0	350/450	140 – 180
5,0	450	180 – 260

Polarity

=(-)~

also available:

find in table of content

Capilla 49 MAG
 Capilla 49 WIG
 Capilla G 460 MM (tubular wire)

Capilla G 460 PM (tubular wire)
 Capilla G 460 RM (tubular wire)
 Capilla G 460 BM (tubular wire)

Standards: EN ISO 2560-A: E 42 4 B 12 H10 (EN 499): E 42 4 B 12 H10 AWS A 5.1: E 7016		<h1>capilla[®] 49 KBS</h1>
Approvals: TÜV, DB		

Product description: Special (double coated) stick electrode suitable especially for crack-free welding at service temperatures in the range of -40°C up to 450°C in all positions; suitable as well on AC.	Applications: For fusion welding of C- and C-Mn-steels such as: S 185 - S 355 JOC, P 235 GH, P 265 GH, P 295 GH, P 120 N - P 360 N, P 255 NH - P 355 NH, GS 38 - GS 52.
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Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Fe
Min.				
Max.	0,06	0,9	0,7	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	550	[MPa]
Yield strength $R_{p0,2}$:	440	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	80	[J]
	50 (-30°C)	[J]

Positions: all except PG

Redrying: 250 - 350°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	2,0	300	50 – 70	=(+)~
	2,5	350	70 – 90	
	3,25	350/450	115 – 135	
	4,0	450	150 – 175	
	5,0	450	190 – 240	

also available:
find in table of content

Capilla 49 MAG
 Capilla 49 WIG
 Capilla G 460 BM (tubular wire)

Capilla G 460 MM (tubular wire)
 Capilla G 460 PM (tubular wire)
 Capilla G 460 RM (tubular wire)

Standards:

EN ISO 3580-A: E Mo B 22
 (EN 1599): E Mo B 22
 AWS A 5.5: E 7018-A1
 Mat.-No.: 1.5424

capilla[®] KB Mo

Product description:

Basic coated stick electrode suitable for welding of boiler and tube steels. Mo-alloyed weld metal for service temperatures up to 550°C.

Applications:

For fusion welding of steel grades as follows:

16 Mo 3, GS-22 Mo4,
 17 Mn 4, 19 Mn 6, GS-C 25.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Mo	Fe
Min.					
Max.	0,06	0,9	0,7	0,5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	560	[MPa]
Yield strength $R_{p0,2}$:	480	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	100	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,0	300	50 – 70
2,5	350	70 – 90
3,25	350/450	115 – 135
4,0	450	150 – 175
5,0	450	190 – 240

Polarity
 =(+)

also available:
 find in table of content

Capilla SG Mo MAG
 Capilla SG Mo WIG

Standards:		capilla[®] CrMo B
EN ISO 3580-A:	E Cr Mo 1 B 42	
(EN 1599):	E Cr Mo 1 B 42	
AWS A 5.5:	~E 8018-B 2	
Mat.-No.:	1.7339	

Product description:	Applications:
Basic coated stick electrode suitable for fusion welding of boiler and tube steels as well as similar CrMo-alloyed, hydrogen pressure resistant steels at service temperatures up to 550°C. Additionally suitable for fusion and overlay welding of similar alloyed hardened and tempered steels.	For fusion welding of steel grades as follows: 13 CrMo 4 4, GS-17 CrMo 5 5, 16 CrMo 4 4, 25 CrMo 4, GS-25 CrMo 4, 22 CrMo 4 4, GS-22 CrMo 5 4, 42 CrMo 4

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Cr	Mo	Fe
Min.						
Max.	0,07	0,9	0,6	1,0	0,5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	580	[MPa]
Yield strength R _{p0.2} :	490	[MPa]
Yield strength R _{p1.0} :	-	[MPa]
Elongation (L=5d):	22	[%]
Impact strength (ISO-V):	100	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	2,0	300	50 – 70	=(+)
	2,5	350	70 – 90	
	3,25	350/450	115 – 135	
	4,0	450	150 – 175	
	5,0	450	190 – 240	

also available:
find in table of content

Capilla CrMo 1 Ti
Capilla SG CrMo 1 MAG
Capilla SG CrMo 1 WIG

Standards:

EN ISO 3580-A: E Cr Mo 1 R 42
 (EN 1599): E Cr Mo 1 R 42
 AWS A 5.5: ~E 8018-B 2
 Mat.-No.: 1.7339

capilla[®] CrMo 1 Ti

Product description:

Rutile coated stick electrode suitable for fusion welding of boiler and tube steels as well as similar CrMo-alloyed, hydrogen pressure resistant steels at service temperatures up to 550°C. Additionally suitable for fusion and overlay welding of similar alloyed hardened and tempered steels.

Applications:

For fusion welding of steel grades as follows:

13 CrMo 4 4, GS-17 CrMo 5 5,
 16 CrMo 4 4, 25 CrMo 4,
 GS-25 CrMo 4, 22 CrMo 4 4,
 GS-22 CrMo 5 4, 42 CrMo 4

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Cr	Mo	Fe
Min.						
Max.	0,08	0,9	0,6	1,1	0,5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	580	[MPa]
Yield strength $R_{p0.2}$:	490	[MPa]
Yield strength $R_{p1.0}$:	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	80	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	300	50 – 70	=(+)~
2,5	350	70 – 90	
3,25	350/450	115 – 135	
4,0	450	150 – 175	
5,0	450	190 – 240	

also available:
 find in table of content

Capilla CrMo B
 Capilla SG CrMo 1 MAG
 Capilla SG CrMo 1 WIG

Standards:

EN ISO 3580-A: E Cr Mo 2 B 42
 (EN 1599): E Cr Mo 2 B 42
 AWS A 5.5: ~E 9018-B 3
 Mat.-No.: 1.7384

capilla[®] CrMo 2 B

Product description:

Basic coated stick electrode suitable for fusion welding of boiler and tube steels as well as similar CrMo-alloyed, hydrogen pressure resistant steels at service temperatures up to 550°C.
 Additionally suitable for fusion and overlay welding of similar alloyed hardened and tempered steels.

Applications:

For fusion welding of steel grades as follows:

Boiler steels: 10 CrMo 9-10,
 11 CrMo 9-10.
 Steel casts: GS 17 CrMo 9-10.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Cr	Mo	Fe
Min.						
Max.	0,08	0,9	0,3	2,2	1,0	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	550	[MPa]
Yield strength R _{p0.2} :	440	[MPa]
Yield strength R _{p1.0} :	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	100	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	300	50 – 70	=(+)~
2,5	350	70 – 90	
3,25	350/450	115 – 135	
4,0	450	150 – 175	
5,0	450	190 – 240	

also available:
 find in table of content

Capilla SG CrMo 2 MAG
 Capilla SG CrMo 2 WIG

Standards:EN ISO 2380-A:
(EN 1599):

EZ CrMo 3 V B 42

E CrMo 3 V B 42

capilla® CrMoV 3**Product description:**

CrMoV-alloyed basic coated stick electrode suitable for welding of similar alloyed steel grades.

Applications:

Welding of heat resistant and high-pressure hydrogen resistant steels used in boilers, vessels and tubings.

Welding of CrMoV-alloyed steels used for oil processing applications.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Cr	Mo	V	Fe
Min.		0,5	0,3	2,8	0,8	0,2	
Max.	0,09	0,6	0,5	3,5	1,1	0,3	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	510	[MPa]
Yield strength R _{p0,2} :	420	[MPa]
Yield strength R _{p1,0} :	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	60	[J]

Positions: all

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,5	350	70 – 90	=(+)
3,25	350/450	115 – 135	
4,0	350/450	150 – 175	
5,0	450	190 – 240	

Standards:

EN ISO 3580-A: E CrMo 5 B 2 2
 (EN 1599): E CrMo 5 B 4 2
 AWS A5.5: E 8015-B6

capilla® CrMo 5 B

Product description:

CrMo-alloyed basic coated stick electrode suitable for welding of similar alloyed steel grades.

Applications:

Welding of heat resistant and high-pressure hydrogen resistant steels used in boilers, vessels and tubings.

Base material: 12 CrMo 19-5.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Cr	Mo	Fe
Min.		0,5	0,5	5,5	0,6	
Max.	0,08	0,6	0,7	6,5	0,7	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	620	[MPa]
Yield strength $R_{p0.2}$:	490	[MPa]
Yield strength $R_{p1.0}$:	-	[MPa]
Elongation (L=5d):	19	[%]
Impact strength (ISO-V):	70	[J]

Positions: all except PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,5	350	70 – 90	=(+)~
3,25	350	115 – 135	
4,0	350/450	150 – 175	
5,0	450	180 – 240	

also available:
 find in table of content

SG CrMo 5 MAG
 SG CrMo 5 WIG

1.2 Wire electrodes for welding of structural and constructional steels

1.2.1 solid wires for gas shielded arc welding of structural and constructional steels

Designation	Standard/ Mat.-No.:	Weld Metal Analysis [Wt. %]								Properties				
		C	Mn	Si	Cr	Ni	Mo	Fe	Ro _{0,2} [MPa]	R _m [MPa]	L=5d [%]	KV (ISO-V) [J]	SG	
capilla®	EN ISO 14341-A EN ISO 21952-A* AWS A5.28** EN ISO 16834-A***													
30 MAG	G 3Si1	0,08	1,5	0,8	-	-	-	Bal.	420	560	25	50 (-50°C)	M21	
49 MAG	G 4Si1	0,08	1,8	1	-	-	-	Bal.	460	620	25	50(-50°C)	M21	
SG Mo MAG	G Mo Si*	1	1,1	0,6			0,5	Bal.	480	570	22	110	M21	
SG CrMo 1 MAG	G CrMo 1 Si*	0,1	1,1	0,6	1	-	0,2	Bal.	510	640	22	95	M21	
SG CrMo 2 MAG	G CrMo 2 Si*	0,06	1,1	0,6	2,4	-	1	Bal.	450	600	20	80	M21	
SG CrMo 5 MAG	G CrMo 5 Si*	0,08	0,55	0,35	6	-	0,65	Bal.	450	550	18	100	M12	
SG NiMo MAG	ER 90S-G**	0,1	1,6	0,5	-	1,3	0,3	Bal.	620	700	18	100	M21	
SG NiMoCr MAG	ER 100S-G**	0,08	1,7	0,6	0,2	1,5	0,5	Bal.	720	780	16	100	M21	
690 F MAG	G 69 6 M Mn4Ni1,5CrMo***	0,1	1,5	0,5	0,2	1,2	0,4	Bal.	700	770	15	100	M21	

Min. values at AT / no heat treatment; shielding gas (SG) acc. EN ISO 14175

Dimensions: Ø 1,0; 1,2; 1,6 [mm]; Spools: K 300; other dimensions and packing units on demand

1.2.2 Welding rods for tungsten inert gas welding of structural and constructional steels

Designation	Standard	Weld Metal Analysis [Wt. %]										Properties				
		C	Mn	Si	Cr	Ni	Mo	Fe	Ro0,2 [MPa]	Rm [MPa]	L=5d [%]	KV (ISO-V) [J]	SG			
capilla®	EN ISO 636-A EN ISO 2192-A* AWS A5.28** EN ISO 16834-A***															
30 WIG	W3Si1	0,08	1,5	0,8	-	-	-	-	-	-	Bal.	420	560	25	50 (-50°C)	I1
49 WIG	W 4Si1	0,08	1,8	1	-	-	-	-	-	-	Bal.	460	620	25	50 (-50°C)	I1
SG Mo WIG	W Mo Si*	1	1,1	0,6	-	-	0,5	Bal.	480	570	22	110				
SG CrMo 1 WIG	W CrMo 1 Si*	0,1	1,1	0,6	1	-	0,2	Bal.	510	640	22	95				
SG CrMo 2 WIG	W CrMo 2 Si*	0,06	1,1	0,6	2,4	-	1	Bal.	450	600	20	80				
SG CrMo 5 WIG	W CrMo 5 Si*	0,08	0,55	0,35	6	-	0,65	Bal.	450	550	18	100				
SG NiMo WIG	ER 90S-G**	0,1	1,6	0,5	-	1,3	0,3	Bal.	620	700	18	100				
SG NiMoCr WIG	ER 100S-G**	0,08	1,7	0,6	0,2	1,5	0,5	Bal.	720	780	16	100				
690 F WIG	G 69 6 M Mn4Ni1,5CrMo***	0,1	1,5	0,5	0,2	1,2	0,4	Bal.	700	770	15	100				

Minimum values at AT / no heat treatment; shielding gas (SG) acc. EN ISO 14175

Dimensions: Ø 1,0; 1,6; 2,0; 2,4 [mm]; Length: 1000 [mm]; other dimensions on demand

1.2.3 Tubular wires for gas shielded arc welding of structural and constructional steels

Designation	Standard	Weld Metal Analysis [Wt. %]										Properties				
		C	Mn	Si	Cr	Ni	Al	Fe	Ro0,2 [MPa]	Rm [MPa]	L=5d [%]	KV (ISO-V) [J]	SG			
capilla®	EN ISO 17632-A															
30 K RLD	T 38 Z W3	0,04	1,2	0,4	-	-	1,4	Bal.	380	520	20	-				OA
G 460 MM	T 46 4 MM 2	0,06	1,3	0,6	-	-	-	Bal.	460	550	24	80				M21
G 460 PM	T 46 4 PM 1	0,06	1,5	0,5	-	-	-	Bal.	460	560	24	140				M21
G 460 BM	T 46 4 BM 3	0,06	1,4	0,45	-	-	-	Bal.	460	560	24	150				M21
G 690 BM	T 69 5 Mn2NiCrMoBM	0,05	1,4	0,3	0,5	2,4	-	Bal.	840	900	20	140				M21

Minimum values at AT / no heat treatment; shielding gas (SG) acc. EN ISO 14175; OA (open-arc) = self shielding tubular wire

Dimensions: Ø 1,2; 1,6 [mm]; Spools: K 300; other dimensions and packing units on demand

capilla



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