



COMPONENT MANUFACTURERS

Tool- and diemakers and saw blade manufacturers
rely on **capilla.**



THE PROBLEM

Erosion, heat, pressure, fatigue and abrasion slowly but surely reduce the product quality and safety. Batch sizes decrease.

More and more often, this results in longer lasting plant downtimes and lets operating costs rise to incalculable amounts.

THE SOLUTION

capilla-products reduce plant downtimes, increase product quality, and thus raise productivity noticeably.

All **capilla**-products were created with more than 50 years of experience in forging, the most demanding welding application.

TYPICAL APPLICATIONS

Forging dies, die casting moulds, stamping tools, saws, bending tools, drilling tools, binders, clamping- and pressing tools.

Demanding welders all over the world put their trust in the **capilla**-quality: in maintenance, repairs and production.

capilla always delivers the most suitable product.

capilla - The number 1 for all demanding metal-workers.

Below you can find a brief extract of the stick-electrode range manufactured by **capilla**, which are specifically used by Component Manufacturers. A number of other products, as well as solutions for other welding processes can alternatively be provided by **capilla**.

	Product Description	Applications	Analysis [weight-%]
51 TI AWS A 5.4: ~E 307-16	Rutile-basic coated stick electrode for fusion welding of dissimilar steels and for cladding. The weld metal consists of austenitic chrome-nickel-manganese steel for service temperatures of up to 300°C.	Welding of dissimilar joints, fusion welding of high carbon steels and work hardening manganese steels e.g. X 120 Mn 12 (1.3401). Fusion welding of "hard to weld" steels. Buffer layers for hardfacing.	C max. 0,1 Cr 17,0-19,0 Ni 7,0-9,0 Mn 5,0-7,0 Fe Rest
410 NI MO AWS A 5.4: E 410 NiMo-25	Basic coated stick electrode for overlay and joint welding of ferritic-martensitic chromium steels. The weld metal is corrosion resistant as similar alloyed chromium (nickel) steels and exhibits a very good resistant against wear and cavitation, especially when used as material of hydraulic turbines. If thick-walled components have to be preheated at 200°C. A post weld heat treatment should be performed to improve the toughness of weld and base metal.	The electrode is suitable for overlay and fusion welding of 13 % chromium (nickel) steels. Suitable for materials such as: 1.4313, 1.4001, 1.4002.	C max. 0,1 Cr 11,5-14,5 Ni 3,0-5,0 Mo 0,5-1,0 Mn max. 0,7 Fe Rest
5201 AWS: ~E 309 Mo-26	High recovery electrode for for welding of crack-free, wear and heat resistant joints and overlays exposed to heavy shock and impact. Fusion welding of dissimilar steels, tool steels, hot working steels, cast steel or manganese steel.	Suitable for fusion and overlay welding on hot forming tools, e.g.: Dies, trimming tools and valve seats. Versatile electrode for repair welding of worn machine parts and for new manufacturing of tools. Suitable for welding of buttering layers of Co-based hardfacings.	C max. 0,04 Cr 22,0-24,0 Ni 10,0-12,0 Mo 2,5-3,5 Fe Rest

Experts trust **capilla**.



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