



FORMING TECHNOLOGY

Forge shops and pressing plants
rely on **capilla**.

THE PROBLEM

Impact, heat, abrasion and pressure slowly but surely reduce the product quality.

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, cutting tools, calibration tools, forging saddles, conveyors and furnaces.

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 in the Forming Technology. A number of other products, as well as solutions for other welding processes can alternatively be provided by **capilla**.

Product Description		Applications	Analysis [weight-%]
<p>64 KBS</p> <p>EN 14700: E Fe 3-350-st</p>	<p>Basic-coated high recovery stick electrode for high-strength, heat treatable fusion and overlay welding. Also suitable as filler for difficult to weld steels.</p> <p>The weld metal is characterized by its high crack resistance and is extremely resistant against compressive and impact stress.</p>	<p>The electrode is used for repair and maintenance welding of all kinds of medium alloyed steels especially constructional and tool steels.</p> <p>Suitable for repair and manufacturing welding of dies, rails, crane rims, support rollers, various machine parts.</p>	<p>C max. 0,1 Cr 2,2-2,7 Si max. 0,5 Mo 2,0-2,5 Mn max. 1,0 Fe Rest</p>
<p>66</p> <p>EN 14700: E Fe 3-55-st</p>	<p>Rutile-basic coated high-recovery stick electrode for overlay welding on heat resistant forming tools.</p> <p>The weld metal is extremely resistant to abrasion, impact and pressure.</p>	<p>This electrode is used for repair welding of hot-forming tools such as dies.</p> <p>Also qualified for new production (contour changes) of dies, as well hard-facing of cold shearing tools.</p>	<p>C max. 0,4 Cr 6,0-8,0 Ni 0,4-0,7 Mo 1,0-1,5 W 6,0-8,0 V 0,5-0,8 Fe Rest</p>
<p>521 EHL</p> <p>EN 14700: E Co 1</p>	<p>High recovery stick electrode for hardfacing of unalloyed, low alloyed and high alloyed steels. The weld metal is heat resistant and shows a good resistance against corrosive media.</p> <p>In the case of friction and sliding wear the alloy has a low friction coefficient against steels.</p> <p>Service temperatures up to 800°C.</p>	<p>High heat resistant special alloy with good high temperature strength. The weld metal shows an excellent resistance against mechanical shock.</p> <p>This electrode is standardally used for the hardfacing of forging dies, punches and hot cutting tools. Furthermore suitable for the cladding of sealing surface of valves used in power plants and chemical industry.</p>	<p>C 0,15-0,30 Cr 30-33 Mo 4,5-5,5 Ni 3,0-4,0 Co Rest</p>

Experts trust **capilla**.



TÜV NORD

CERTIFICATE

Management system as per
DIN EN ISO 9001 : 2015

In accordance with TÜV NORD CERT procedures, it is hereby certified that

Capilla Schweißmaterialien GmbH
Westring 48 - 50
33818 Leopoldshöhe
Germany

applies a management system in line with the above standard for the following scope

Development, manufacture and sale of welding consumables

Certificate Registration No. 04 100 960464
Audit Report No. 3520 8477

Valid from 2018-02-20
Valid until 2021-02-19
Initial certification 1996

Jensom Landell
Certification Body
at TÜV NORD CERT GmbH

Essen, 2018-01-29

This certification was conducted in accordance with the TÜV NORD CERT auditing and certification procedures and is subject to regular surveillance audits.

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