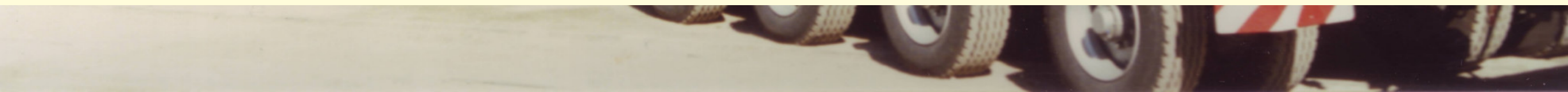


# LARGE PLANT FACILITIES

.....  
Manufacturers of pumps, valves, fittings, pipes, containers, appliances, facilities and power plants rely on **capilla**.



## THE PROBLEM

Erosion, cavitation, heat, pressure, fatigue, abrasion and corrosion slowly but surely reduce the process safety and lead to a declining efficiency.

This likely results in an environmentally harmful component failure or even worse, plant downtime, which leads to rising operating costs at incalculable levels.

## THE SOLUTION

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

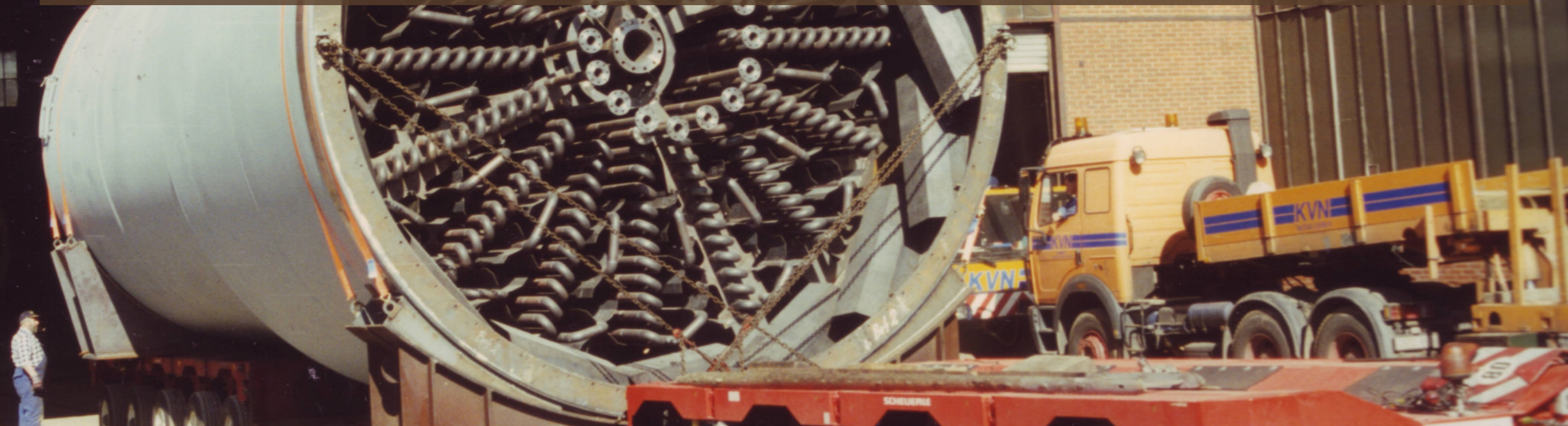
All **capilla**-products were created with more than 50 years of experience in forging, the most demanding welding application.

## TYPICAL APPLICATIONS

Pumps, valves, sealing elements, casings, flanges, pipes, wear protection, containers, tanks, boilers, armatures, fuel mills, bulk material transport equipment, turbines, digested sludge presses, desulphurizer.

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 at Large Plant Facilities. A number of other products, as well as solutions for other welding processes can alternatively be provided by **capilla**.

Product Description		Applications	Analysis [weight-%]	
<b>30 W</b> AWS A 5.1: E 6013	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 weld metal the weld seams can be galvanised without any problems.	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	C	max. 0,08
<b>385</b> AWS A 5.4: E 385 L-26	Rutil-basic coated stick electrode for fusion and overlay welding of similar alloyed corrosion resistant steels. High resistance against phosphoric acid and stress corrosion cracking in fluids containing chloride.	Suitable for materials as:  1.4500, 1.4505, 1.4506, 1.4531, 1.4539, 1.4573, 1.4585, 1.4586.	Mn	max. 0,5
<b>4018</b> AWS SFA-5.4: ~E 410-25	Basic coated stick electrode suitable for overlays of sealing surfaces at gas, water and steam fittings up to service temperatures of 450°C. The weld metal is corrosion resistant as similar alloyed chromium steels. It is recommended to preheat the work piece to approx. 250°C. A stress-relief heat treatment at TPWHT up to 680°C is recommended.	The electrode is suitable for overlay and fusion welding of heat treatable steels with 13 % Cr. Often used as filler material for cover passes on austenitic fusion weldings (e.g. in sulphurous media at higher temperatures). Suitable for materials like: 1.4008.	Si	max. 0,3
			Fe	Rest
			C	max. 0,03
			Cr	19,0-21,0
			Ni	24,0-26,0
			Mo	4,0-5,0
			Mn	1,2-1,8
			Cu	1,2-1,8
			Fe	Rest
			C	max. 0,1
			Cr	11,5-13,5
			Ni	1,5-2,0
			Fe	Rest

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.

TÜV NORD CERT GmbH    Langemarckstraße 20    45141 Essen    [www.tuev-nord-cert.com](http://www.tuev-nord-cert.com)

**capilla Schweißmaterialien GmbH**

Westring 48-50 D-33818 Leopoldshöhe  
T +49 (0)5202 97790-0 F +49 (0)5202 97790-19  
[info@capilla-group.com](mailto:info@capilla-group.com) [www.capilla-group.com](http://www.capilla-group.com)