MECHANICAL ENGINEERING

Mechanical engineers and the automotive industry rely on **capilla**.

THE PROBLEM

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

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.

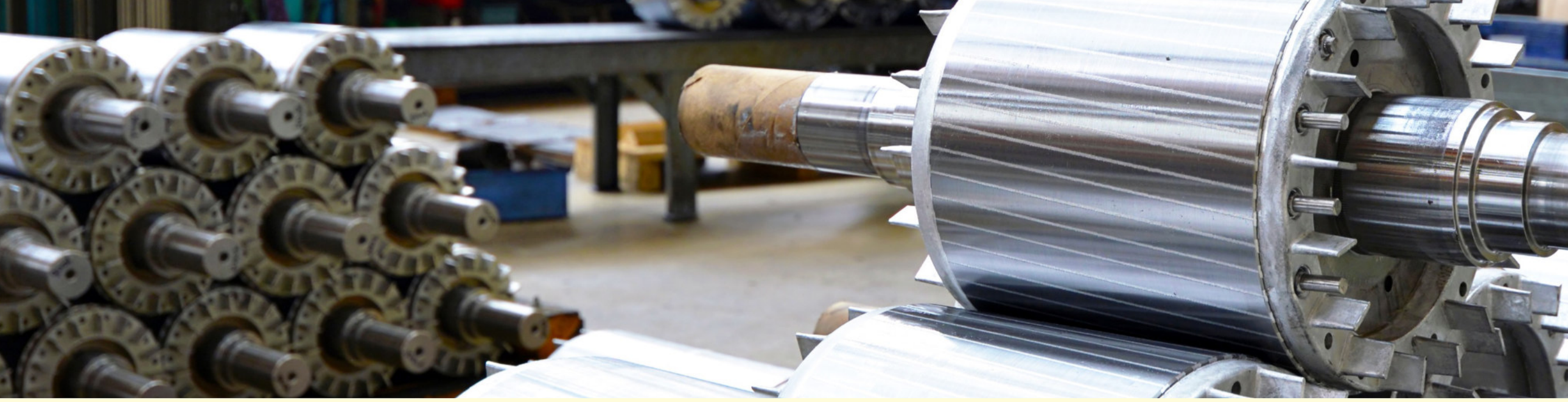
All **capilla**-products were created with more than 50 years of experience in forging, the most demanding welding application.

TYPICAL APPLICATIONS

Machine tool tables, casings, shaft hub-connections, bolts, manufacturing plants and conveyors, die casting machines.

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 Mechanical Engineering. A number of other products, as well as solutions for other welding processes can alternatively be provided by **capilla.**

	Product Description	**Applications**	**Analysis** [weight-%]
30-170 AWS A 5.1: E 7024-1	Rutile coated stick with very high recovery. Short periodes of welding and high length of bead deposited grant economical welding of fillets. Welding under contact, this electrode allowes best concave fillet welds. Good bridging over of gaps. The slag is easy to remove.	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 Mn max. 0,6 Si max. 0,3 Fe Rest
506 K AWS: E Co Cr-A	Core wire alloyed stick electrode for overlays on working surfaces stressed by heavy impact and shock and simultaneous exposed to elevated temperatures. The weld metal has a good resistance against cavitation and erosion. Welded surfaces have good sliding properties (metal to metal) and are resistant to thermal shocks. Microstructure: Cr- and W-carbides embedded in austenitic Co-base matrix	For overlays on sealing surfaces of steam-, gas-, water- and acid-fittings, valve seats of combustion engines. Also suitable for hardfacing of edges of billet shears, hot extruder nozzles, sawteeth (wood processing) etc.	C 1,2-1,4 Cr 26,0-30,0 W 4,0-6,0 Co Rest
60 HRC AWS: A Fe Cr A1	Rutile-coated high recovery stick electrode for welding of highly wear resistant overlays at machine parts which are exposed to high emery wear caused by abrasive substances.	Hardfacing of moulds, agitator blades, dredger teeth, guidance, slides, components of hoisting devices etc. which are exposed to heavy abrasive wear in combination with moderate pressure or impact. Base materials: mild steels, low alloyed steels, steel casts and high-manganese steel.	C 3,5-4,2 Cr 28,0-32,0 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

capilla
Internationale Schweißkompetenz
Made in 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

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

IAF

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Deutsche Akkreditierungsstelle
D-ZM-12007-01-01

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