



PRIMARY FORMING TECHNOLOGY

Foundries rely on **capilla**.



THE PROBLEM

Abrasion, erosion and heat slowly but surely reduce the product quality. Components fail.

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 profoundly raise productivity.

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

TYPICAL APPLICATIONS

Manufacturing plants, mould frames, casting channels, plants for moulding sand preparation, pressure casting moulds and machines, production welding in castings.

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 Primary 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-%]	
52 K AWS A 5.4: E 312-16	<p>Rutile-basic coated stick electrode for joint welding of dissimilar steels; very good suitability for buffer layers and overlay weldings.</p> <p>The electrode produces a very soft arc and self-removing slags; easy to weld without any splatters. The weld metal has a ferritic-austenitic microstructure (high strength duplex stainless steel).</p>	<p>Corrosion resistant like similar alloyed steel and steel cast e.g. 1.4762 (X 10 CrAl 24), 1.4085 (G-X 70 Cr 29). Suitable for difficult to weld steels, e.g. constructional steel with high tensile strength, cladding of rail steels, fusion welding of high alloyed manganese steels and joints of this steels with high-alloyed steel, suitable for repair and maintenance.</p>	C Cr Ni Fe	max. 0,1 27,5-30,0 8,0-10,0 Rest
4853 EN 14700: ~E Ni 1	<p>Basic coated high-recovery stick electrode suitable for welding of high heat resistant steel casts.</p> <p>The weld metal is scaling resistant at service temperatures up to 1050°C.</p>	<p>Fusion welding and cladding of similar alloyed heat resistant steels and steel casts e.g.</p> <p>Material No.: 1.4852.</p>	C Cr Ni Nb Mn Fe	0,3-0,5 25,0-27,0 34,0-36,0 1,2-1,5 0,9-1,1 Rest
45-2 AWS: E NiFe-C1	<p>Special flux coated stick electrode with a nickel-iron alloyed bi-metal core wire for repair and maintenance of cast iron.</p> <p>Due to the special core wire even higher amperage can be used. The welding properties of the electrode are excellent. The seams are free of blow holes. The deposits can be machined excellently. Carbon is precipitated as graphite in the weld metal.</p>	<p>For cold welding of grey cast iron, malleable cast iron and nodular cast iron.</p>	C Ni Fe	max. 1,5 51,0-55,0 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

Jenssen-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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