

<b>Standards:</b> EN ISO 1071: (DIN 8573): AWS:	E FeC-GP2 1 E FeC-G E St	<b>capilla<sup>®</sup> 41</b>
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<b>Product description:</b>  Special coated stick electrode suitable for repair and maintenance welding of grey cast iron. Characteristics of weld metal:  Ni-alloyed Fe-base alloy with high content of carbon  If heat treated correctly and if composition of the base material is suitable, the weld metal is mainly perlitic with embedded globular carbon.  Pre-heating of base material in the range between 600°C and 650°C.	<b>Applications:</b>  For cold welding of grey cast iron, malleable cast iron and nodular cast iron.  Base metals: EN 1561: EN-GJL-100 (GG10) to EN-GJL-350 (GG 35). EN 1562: EN-GJMB-350 (GTS 35) to EN-GJMB-550 (GTS 55). EN-GJMW-350 (GTW 35) to EN-GJMW-550 (GTW 55). EN 1563: EN-GJS-400 (GGG40) to EN-GJS-700 (GGG 70).
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**Typical weld metal composition:**

[wt. - %]

	C	Si	Mn	Ni	Ti	Fe
<b>Min.</b>	2,0	1,5	0,8	1,5	0,3	
<b>Max.</b>	2,5	2,0	1,0	2,5	0,5	Bal.

**Mechanical properties:**

The mechanical properties of the deposit are mainly influenced by the base material and the heat treatment during and after welding.

Positions: PA  
Redrying: 150 – 180°C/2h

<b>Dimension:</b>	<b>Ø [mm]</b>	<b>Length [mm]</b>	<b>Welding current [A]</b>	<b>Polarity</b> =(-)~
	2,5	350	60 - 80	
	3,25	350	80 - 120	
	4,0	350	110 - 140	
	5,0	350	140 - 180	