

<b>Standards:</b> EN 14700: E Fe 15-60-cg (DIN 8555): E 10-UM-65-GRZ		<b>capilla<sup>®</sup> 540</b>
<b>Recovery:</b>	<b>150%</b>	

<b>Product description:</b>  Rutile-coated high recovery stick electrode for welding of highly wear resistant overlays at machine parts which are exposed to wear caused by abrasive substances. Base material: mild steels, low alloyed steels, steel casts and high-manganese steel.	<b>Applications:</b>  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.
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**Typical weld metal composition:**

[wt. - %]

	C	Cr	Fe
Min.	4,7	32	
Max.	5,2	35	Bal.

**Mechanical properties:**

(without heat treatment; minimum values at ambient temperature)

Hardness:	60 – 63	[HRC]
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Positions: PA, PB

Redrying: 320°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	3,25	350	100 – 160	=(+)~
	4,0	450	160 – 220	
	5,0	450	190 – 260	

**also available:**  
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Capilla 540 RLD  
Capidur 60 FeCr