

<b>Standards:</b> EN 14700: E Fe 7-55-gpt (DIN 8555): E 6-UM-60 Mat.-No.: ~ 1.4718	capilla <sup>®</sup> 54 W
<b>Recovery:</b> 120%	

<b>Product description:</b>  Basic coated Cr-Mo-V-alloyed stick electrode for tough and wear-resistant deposits on parts that are subject to abrasive wear and heavy impacts. Deposits without cracks and pinholes. Deposit thickness as required.	<b>Applications:</b>  Hardfacing of dredger teeth, crusher jaws, screw conveyors, coal cutters, beaters, edge runners, hammers etc.
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### Typical weld metal composition:

[wt. - %]

	C	Cr	Mn	Mo	V	Fe
Min.	0,5	7	0,5	0,5	1	
Max.	0,8	10	0,7	1	1,2	Bal.

### Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Hardness:	54 – 60	[HRC]
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Positions: all except PG

Redrying: 300°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	2,5	350	80 – 120	=(+)~
	3,25	350	100 – 160	
	4,0	450	160 – 220	
	5,0	450	190 – 260	
	6,0	450	220 – 290	

**also available:**  
find in table of content

Capilla 54 Ti  
Capilla 54 MAG

Capilla 54 WIG  
Capilla G 54 MM (tubular wire)