

CARBO RR 11

International standards	DIN EN ISO 2560-A	E 42 0 RR 73
	AWS A 5.1	E7024

Typical applications and characteristics

Heavy coated, rutile type high efficiency electrode having a weld metal recovery of 160%. Is preferred for economically filling of large weld sections and long fillets. Produces very smooth, concave and clean welds, merging into base metal without undercuts. Suitable for welding prepainted and galvanized plates. Easy arc striking and restriking. Slag is self-releasing.

Operating temperature From +/- 0 up to + 350 °C

Base materials

DIN EN 10025	S235JRG1, S235JRG2, S235JRG3, S275JR, S275J2G3, S355J2G3
DIN EN 10028-2	P235GH, P265GH, P295GH, P355GH
DIN EN 10028-3	P275N, P355N
DIN 17100	St 37-2, St 44-2, St 52-3
DIN 17175	St 35.8, St 45.8, 17 Mn 4, 19 Mn 5
DIN 17102	StE 255 – StE 355
DIN 17172	StE 210. 7 – StE 360.7 TM
DIN 17155	H I, HII, 17 Mn 4, 19 Mn 6
Schiffbaustähle:	A - B - D

Mechanical properties of all-weld metal (typical values)

Tensile strength R _m N/mm ²	Yield strength R _{eL} N/mm ²	Elongation A ₅ %	Impact energy ISO – V J +/- 0° C
510	> 420	> 22	> 47

Weld metal analysis (typical, wt %)

C	Si	Mn
0.07	0.4	0.7

Current = - / ~ 65 V (= + on certain conditions)

Welding positions PA, PB

Rebaking 1 h, 240 °C +/- 10 °C (if necessary)

Dimensions Current intensity No. of pieces/net weights (typical values)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	Kg/1000 pcs.	Kg/packet	Kg/carton
3,2 x 450	130 - 170	94	376	63,8	6,0	24
4,0 x 450	150 - 210	59	236	101,7	6,0	24
5,0 x 450	200 - 310	39	156	153,8	6,0	24

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