CARBO BR 10 D

EN ISO 2560-A: E 42 4 B 32 H10
AWS A5.1: E7018

Approvals

TÜV, CE

Typical application and characteristics

CARBO BR 10 D is a double basic coated electrode of excellent welding characteristics combined with outstanding mechanical properties. Very well suitable for AC welding (also with small transformers). The double coating provides optimal welding characteristics even in constrained welding positions. Smooth weld aspect, free of penetration notches. Recovery 120%, H2 content < 8 ml/100g.

Operating temperature -40°C up to +450°C

Weld metal analysis (typical)

	C	Si	Mn					
wt.-%	0,06	0,7	0,9					

Base materials

DIN EN 10025 :	S235JRG1, S235JRG2, S235JRG3, S275JR,S275J2G3, S355J2G3
DIN EN 10028-2:	P235GH, P265GH, P295GH, P355GH
DIN EN 10028-3:	P275N, P275NH, P275NL2, P355N, P355NH, P420NL1
DIN 17155:	H I, HII, 17 Mn 4, 19 Mn 6

Mechanical properties of all-weld metal (typical values)

Tensile strength R_m Mpa:	>510	Impact strength ISO-V KV J at	-40°C	>47 J
Yield strength $R_{p0.2}$ Mpa:	>420			
Elongation A ($L_0 = 5d_0$):	>22			

Operating data

Current:	=+
Welding positions:	PA, PB, PC, PD, PE, PF
Rebaking:	1 h, 300°C +/- 10°C (if nacessary) 1 h, 400° C = < 5ml hydrogen

Dia./Length	Amperage (A)	Pcs. / packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	60 - 90	215	860	20,9	4,5	18,0
3,2 x 350	90 - 140	128	512	35,2	4,5	18,0
3,2 x 450	90 - 140	119	476	46,2	5,5	22,0
4,0 x 450	140 - 190	77	308	71,4	5,5	22,0
5,0 x 450	190 - 230	51	204	107,8	5,5	22,0