

## CARBO Mn B

International standards		EN	ISO 2560-A	E 42 6 B	42 H	5			
		AW	S A 5.1	E7018-1					
Approvals		TÜ	/, DB, CE						
Typical applications and characteristics		CARBO Mn B is a low hydrogen, AC weldable electrode with about 120% recovery. The weld deposit has high mechanical properties which qualifies this product for constructional jobs with high mechanical load. The deposit is safe upon hot- and cold-cracking. The electrode can be welded in all positions and slag removal is easy This field of application of this electrode is universal but it is typically applied for weldings on rails with high carbon contents ( up to 0,6% C)							
Operating te	mperature	From -40 up to + 450 °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, P275NH, P275NL2, P460N, P460NH, P460NL1   DIN 17100 St 37-2, St 44-2, St 52-3, ST 50-2, St 60, St 70   DIN 17175 St 35.8, St 45.8, 17 Mn 4, 19 Mn 5   DIN 17102 StE 255 – StE 460, WStE 255 – WStE 460, TStE 255 – TStE 460   DIN 17172 StE 210. 7 – StE 445.7 TM							
		DIN	17155	H I, HII, 17 Mn	4, 19	Mn 6			
Mechanical   of all-weld m		Ten	sile strength	Yield streng	jth	Elonga	-		t strength / J- 40° C
	netal	Ten		1	jth		6	ISÓ – V	t strength / J- 40° C > 47
of all-weld m	netal es) analysis	<b>Ten</b> <b>C</b>	sile strength R <sub>m</sub> N/mm <sup>2</sup> 600 Si	Yield streng R <sub>eL</sub> N/mm²	jth	Elonga A₅ %	6	ISÓ – V	/ J- 40° C
of all-weld m ( typical value Weld metal a (typical. wt %	netal es) analysis )	<b>Ten</b> 0.0	sile strength R <sub>m</sub> N/mm <sup>2</sup> 600 Si 06 0.4	Yield streng R <sub>eL</sub> N/mm <sup>2</sup> > 460 Mn 1,4	jth	Elonga A₅ %	6	ISÓ – V	/ J- 40° C
of all-weld m ( typical value Weld metal a (typical. wt % Current	netal es) analysis )	<b>Ten</b> 0.0 = + PA.	<b>Sile strength</b> <b>R</b> <sub>m</sub> N/mm <sup>2</sup> 600 <b>Si</b> 06 0.4 / ~ / 65 V	Yield streng R <sub>eL</sub> N/mm <sup>2</sup> > 460 Mn 1,4 PE. PF.	ith 2	Elonga A <sub>5</sub> % > 22	6	ISÓ – V	/ J- 40° C
of all-weld m ( typical value Weld metal a (typical. wt % Current Welding pos	netal es) analysis ) itions	<b>Ten</b> 0.( = + PA. 1 h.	<b>Sile strength</b> R <sub>m</sub> N/mm <sup>2</sup> 600 <b>Si</b> 06 0.4 / ~ / 65 V PB. PC. PD. F	Yield streng R <sub>eL</sub> N/mm <sup>2</sup> > 460 Mn 1,4 PE. PF.	cessa	Elonga A <sub>5</sub> % > 22	6	<u>ISO – V</u> >	/ J- 40° C
of all-weld m ( typical value Weld metal a (typical. wt % Current Welding pos Rebaking Dia./Length 2,5 x 350	netal analysis ) hitions Amperage 80 - 110	Ten 0.0 = + PA. 1 h. 0	sile strength R <sub>m</sub> N/mm <sup>2</sup> 600 Si 06 0.4 / ~ / 65 V PB. PC. PD. F 350 °C + / - 10	Yield streng R <sub>eL</sub> N/mm <sup>2</sup> > 460 Mn 1,4 PE. PF. 0 °C (if neo	th 2 cessa	Elonga A5 % > 22	<b>6</b>   2	ISO – V >	/ J- 40° C → 47
of all-weld m ( typical value Weld metal a (typical. wt % Current Welding pos Rebaking Dia./Length 2,5 x 350 3,2 x 350	etal es) analysis ) itions <u>Amperage</u> 80 - 110 110 - 140	Ten 0.( = + PA. 1 h. (A) 0	sile strength R <sub>m</sub> N/mm <sup>2</sup> 600 Si 06 0.4 / ~ / 65 V PB. PC. PD. F 350 °C + / - 10 Pcs./packet 223 139	Yield streng R <sub>eL</sub> N/mm <sup>2</sup> > 460 Mn 1,4 PE. PF. 0 °C (if neo Pcs./carton 670 417	cessa kg	Elonga A5 % > 22 ry) / 1000 22,4 36,0	<b>kg / pa</b> 5, 5,	acket 0 0	<b>/ J- 40° C</b> 47 47 15,0 15,0
of all-weld m ( typical value Weld metal a (typical. wt % Current Welding pos Rebaking Dia./Length 2,5 x 350	netal analysis ) hitions Amperage 80 - 110	Ten 0.( 0.( = + PA. 1 h. (A) 0 0	sile strength R <sub>m</sub> N/mm <sup>2</sup> 600 Si 06 0.4 /~/65 V PB. PC. PD. F 350 °C + / - 10 Pcs./packet 223	Yield streng R <sub>eL</sub> N/mm <sup>2</sup> > 460 Mn 1,4 PE. PF. 0 °C (if neo Pcs./carton 670	cessa kg	Elonga A5 % > 22 ry) / 1000 22,4	<b>kg / pa</b> 5,	<b>acket</b> 0 0 5	<b>/ J- 40° C</b> 47 47 15,0

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Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.