

CARBO SPECIAL

EN ISO 2560-A: E 42 3 B 12 H10

AWS A5.1: E7018



Approvals

TÜV, DB, CE

Typical application and characteristics

CARBO SPECIAL 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 -30°C up to +450°C

Weld metal analysis (typical)

wt.-%	C	Si	Mn				
	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	-30°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 necessary) 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	259	777	19,3	5,0	15,0
3,2 x 350	90 - 140	151	453	33,1	5,0	15,0
3,2 x 450	90 - 140	154	162	42,2	6,5	19,5
4,0 x 450	140 - 190	101	303	64,4	6,5	19,5
5,0 x 450	190 - 230	65	195	100,2	6,5	19,5