

CARBO RR 11

International standards	EN 499	E 42 0 RR 73
	AWS A 5.1	E7024

Approvals TÜV, DB, CE

Typical applications and characteristics

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	89	267	67,4	6,0	18,0
4,0 x 450	150 - 210	57	171	105,1	6,0	18,0
5,0 x 450	200 - 310	37	111	162,0	6,0	18,0

Rev. 000