

<b>International standards</b>	EN ISO 2560-A	E 38 2 RB 12
	AWS A 5.1	E6013

**Approvals** TÜV, DB, CE, GL

**Typical applications and characteristics** Rutile-basic coated electrode with fast-flowing weld metal, suitable for welding for construction elements made of structural steels up to ST-52-3 which are subject to dynamic stress, as used in bridge-, pipeline-, container-, vessel- and shipbuilding.  
The weld metal has outstanding mechanical properties and is highly crack-resistant. In constrained welding positions, and also when root welding on pipes, CARBO RRB 7 proves its good weldability and produces smooth welds without any penetration notches.

**Operating temperature** From -20 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, P275NH, P275NL2, P355N, P355NH, P355NL1
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, WStE 255 – WStE 355, TStE 255 – TStE 355
DIN 17172	StE 210. 7 – StE 360.7 TM
DIN 17155	H I, HII, 17 Mn 4, 19 Mn 6

<b>Mechanical properties of all-weld metal</b> ( typical values )	<b>Tensile strength</b>	<b>Yield strength</b>	<b>Elongation</b>	<b>Impact strength</b>
	<b>R<sub>m</sub> N/mm<sup>2</sup></b>	<b>R<sub>eL</sub> N/mm<sup>2</sup></b>	<b>A<sub>5</sub> %</b>	<b>ISO-V J - 20°C</b>
	> 510	> 380	> 22	> 47

<b>Weld metal analysis</b> (typical wt %)	<b>C</b>	<b>Si</b>	<b>Mn</b>
	0.08	0.3	0.6

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

**Welding positions** PA. PB. PC. PD. PE. PF.

**Rebaking** 1 h. 100 °C + / - 10 °C (if necessary)

<b>Dia./Length</b>	<b>Amperage (A)</b>	<b>Pcs./packet</b>	<b>Pcs./carton</b>	<b>kg / 1000</b>	<b>kg / packet</b>	<b>kg / carton</b>
2,5 x 350	60 - 100	248	990	20,2	5	20
3,2 x 350	90 - 140	150	600	33,2	5	20
4,0 x 350	110 - 190	97	388	51,5	5	20
5,0 x 450	180 - 240	59	236	102,2	6	24

Rev. 000

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.