

CARBO SPECIAL

International standards	EN ISO 2560-A	E 38 2 B 12 H10
	AWS A 5.1	E7016-H8

Approvals TÜV, DB, CE

Typical applications 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.

Operating temperature - 20 up to + 450 °C

Base materials

DIN EN 10025	S235JRG1, S235JRG2, S235JRG3, S275JR, 275J2G3, 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, ST 50-2
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

Ship building steels A/B/D/E ; A 32- D32 ; E 32 ; A 36 - D36 ; E 36

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 strength ISO – V J - 20°C
530	> 420	> 22	> 47

Weld metal analysis
(typical, wt %)

C	Si	Mn
0.07	0.4	0,7

Current = +/- / ~ / 42 V

Welding positions PA, PB, PC, PD, PE, PF,

Rebaking 1 h, 300 °C +/- 10 °C (if necessary)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	50 - 90	259	777	19,3	5,0	15,0
3,2 x 350	90 – 150	151	453	33,1	5,0	15,0
3,2 x 450	90 – 150	154	462	42,2	6,5	19,5
4,0 x 450	120 – 190	101	303	64,4	6,5	19,5
5.0 x 450	160 – 230	65	195	100,2	6,5	19,5

Rev. 001

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.