CARBO WELD
SCHWEISSMATERIALIEN GMBH

CARBO B 10 Ni

International standards	AWS A 5.1	E8018 C1

Typical applications and characteristics

CARBO B 10 Ni is a universal basic coated electrode for welding highly stressed joints with high security. Resistant to cold cracks - easy slag removal.
Very good welding characteristics - can also be used in constrained welding positions. Fast solidifying weld metal - allows position welding at high amperage.

Operating temperature

From -60° C bis +450 °C

Mechanical properties of all-weld metal (typical values)

Tensile strength R_m N/mm²	Yield strength R_{eL} N/mm²	Elongation A_5 %	Impact strength ISO – V J - 40°C
>520	> 420	> 20	> 80

Weld metal analysis (typical, wt %)

C	Si	Mn	Ni
0,05	0,5	1,25	2,0 – 2,5

Current

= +

Welding positions

PA, PB, PC, PD, PE, PF,

Rebaking

1 h, 350° 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	80 - 110	208	832	21,6	4,5	18,0
3,2 x 350	110 - 150	123	492	36,6	4,5	18,0
4,0 x 450	140 - 200	81	324	74,0	6,0	24,0

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.