CARBO WELD
SCHWEISSMATERIALIEN GMBH

CARBO RC 3

International standards	EN ISO 2560	E 38 0 RC 11
	AWS A 5.1	E6013

Approvals   TÜV, DB, CE

Typical applications and characteristics   CARBO RC 3 is a medium-thick rutile-cellulose coated electrode for constrained position welding. It is suitable for universal application in structural steel engineering, industrial engineering, shipbuilding and vehicle construction. Particularly suitable for assembly welding on galvanized and primered sheets.
Performs good results in all welding positions. Stable arc and easy reiginition. The viscous weld metal performs good results in gap bridging.

Operating temperature   - 10 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

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 +/- 0° C
510	> 420	> 22	> 47

Weld metal analysis (typical. wt %)

C	Si	Mn
0.07	0.3	0.5

Current   = - / ~ / 42 V

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

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

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg / 1000	kg / packet	kg / carton
2,0 x 300	50 - 80	400	1200	10,0	4,0	12,0
2,5 x 350	75 - 100	270	811	18,5	5,0	15,0
3,2 x 350	90 - 130	167	500	30,0	5,0	15,0
4,0 x 350	130 - 180	110	330	45,4	5,0	15,0
5,0 x 450	180 - 240	67	200	90,0	6,0	18,0

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