

# CARBO RC 3 blau

<b>International standards</b>	EN ISO 2560-A	E 38 0 RC 11
	AWS A 5.1	E 6013

**Approvals** TÜV, DB, CE

**Typical applications and characteristics** CARBO RC 3 blau 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 primed sheets. Performs good results in all welding positions. Stable arc and easy restriking. 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. III. 17 Mn 4. 19 Mn 6

**Mechanical properties of all-weld metal**  
( typical values)

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{eL}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Impact strength ISO-V J + 20°C
500	> 380	> 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	40 - 65	421	1263	9.5	4.0	12.0
2.5 x 350	65 - 85	265	794	18.9	5.0	15.0
3.2 x 350	95 - 145	160	481	31.2	5.0	15.0
4.0 x 350	125 - 210	111	333	45.1	5.0	15.0
5.0 x 450	180 – 240	69	276	87,0	6,0	24,0

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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.