CARBO RRB 7

International standards	EN ISO 2560-A	E 38 2 RB 12
	AWS A 5.1	E6013

Approvals TÜV, DB, CE

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 mecanical 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

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 - 20°C
> 510	> 380	> 22	> 47

Weld metal analysis (typical wt %)

C	Si	Mn
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)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg / 1000	kg / packet	kg / carton
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

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