

CARBO B 10

International standards	EN ISO 2560-A	E 42 6 B 42 H5
	AWS A 5.1	E7018

Approvals TÜV, DB, CE

Typical applications and characteristics CARBO B 10 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 -60°C up to + 450°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, P420NL1
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 420, WStE 255 . WStE 420, TStE 255 . TStE 420, EStE 255 . EStE 420
DIN 17172	StE 210. 7 . StE 415.7 TM
DIN 17155	H I, HII, 17 Mn 4, 19 Mn 6

Shipbuilding steels: A - B - D . E, A36, D36, E36, F32, F36

Mechanical properties of all-weld metal
(typical values)

Tensile strength Rm N/mm	Yield strength ReL N/mm ²	Elongation A5 %	Impact strength ISO . V J - 60°C
530	>420	>22	>47

Weld metal analysis
(typical, wt %)

C	Si	Mn
0,06	0,4	1,2

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 300	80 - 110	223	670	22,4	5,0	15,0
3,2 x 350	110 - 150	139	417	36,0	5,0	15,0
3,2 x 450	110 - 150	144	433	45,0	6,5	19,5
4,0 x 350	140 - 200	95	285	68,4	6,5	19,5
5,0 x 450	200 - 260	62	186	105,0	6,5	19,5
6,0 x 450	230 - 280	39	156	156,2	6,0	24,0