

CARBO LC

International standards	EN 499	E 38 ARR 12
	DIN 1913	E 43 11 RR 8
	AWS A 5.1	E 6013

Approvals

Typical applications and characteristics

CARBO LC is a heavy rutile coated electrode. Suitable for welding thin Armco irons and low carbon steels. Especially used in fabrication and repair weld of molten zinc bath tanks made of Armco iron and very low carbon steels. Weld metal ensures high crack resistance against the effect of molten zinc. Possible to use equally well both with AC and DC.

Operating temperature

Base materials 1.0340 M 2 (Armco iron)

Mechanical properties of all-weld metal (typical values)

Tensile strength R_m N/mm ²	Yield strength R_{eL} N/mm ²	Elongation A_5 %	Impact strength ISO - V J + 20° C
440	380	25	70

Weld metal analysis (typical. wt %)

C	Si	Mn
0.03	0.15	0.20

Current = - / ~ / 42 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
3.2 x 350	80 - 140	154	462	32,4	5,0	15,0
4.0 x 350	120 - 200	100	300	49,7	5,0	15,0
5.0 x 350	160 - 280	65	195	76,2	5,0	15,0

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.