

CARBO RRB 7

International standards	EN 499	E 38 2 RB 12
	AWS A 5.1	E 6013

Approvals TÜV, GL, DB, Ü, UDT

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 mechanical 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 -10 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, 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	Yield strength	Elongation	Impact strength
	R _m N/mm ²	R _{eL} N/mm ²	A ₅ %	ISO-V J - 20°C
	460	> 350	> 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 250	60 – 100	269	1077	13.0	3.5	14.0
2.5 x 350	60 – 100	255	900	29,4	4,4	17,6
3.2 x 350	90 – 140	125	500	33.0	4,3	17,2
4.0 x 350	110 – 190	104	417	48.0	5.0	20.0
5.0 x 450	180 – 240	72	289	83.0	6.0	24.0