

CARBO Mn B

International standards	EN ISO 2560-A	E 42 6 B 42 H5
	AWS A 5.1	E7018-1

Approvals TÜV, DB, CE

Typical applications and characteristics CARBO Mn B is a low hydrogen, AC weldable electrode with about 120% recovery. The weld deposit has high mechanical properties which qualifies this product for constructional jobs with high mechanical load. The deposit is safe upon hot- and cold-cracking. The electrode can be welded in all positions and slag removal is easy. This field of application of this electrode is universal but it is typically applied for weldings on rails with high carbon contents (up to 0,6% C)

Operating temperature From -40 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, P460N, P460NH, P460NL1
DIN 17100	St 37-2, St 44-2, St 52-3, ST 50-2, St 60, St 70
DIN 17175	St 35.8, St 45.8, 17 Mn 4, 19 Mn 5
DIN 17102	StE 255 – StE 460, WStE 255 – WStE 460, TStE 255 – TStE 460
DIN 17172	StE 210. 7 – StE 445.7 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- 40° C
	600	> 460	> 22	> 47

Weld metal analysis (typical. wt %)	C	Si	Mn
		0.06	0.4

Current = + / ~ / 65 V

Welding positions PA. PB. PC. PD. PE. PF.

Rebaking 1 h. 350 °C + / - 10 °C (if necessary)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	80 - 110	223	670	22,4	5,0	15,0
3,2 x 350	110 - 140	139	417	36,0	5,0	15,0
4,0 x 450	140 - 190	95	285	68,4	6,5	19,5
5,0 x 450	200 - 260	61	183	106,5	6,5	19,5

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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.