

# CARBO RC 3

<b>International standards</b>	EN 499	E 38 0 RC 11
	AWS A 5.1	E 6013

**Approvals** TÜV, DB, GL, Ü, UDT

**Typical applications and characteristics** CARBO RC 3 is a medium-thick rutile-cellulose coated electrode for constrained position welding. It is suitable for universal application in structural steel engineering, industrial engineering, shipbuilding and vehicle construction. Particularly suitable for assembly welding on galvanized and primed sheets. Performs good results in all welding positions. Stable arc and easy re-ignition. The viscous weld metal performs good results in gap bridging.

**Operating temperature** +/- 0 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. P355N  
 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  
 DIN 17172 StE 210. 7 – StE 360.7 TM  
 DIN 17155 H I. HII. 17 Mn 4. 19 Mn 6

<b>Mechanical properties of all-weld metal (typical values)</b>	<b>Tensile strength R<sub>m</sub> N/mm<sup>2</sup></b>	<b>Yield strength R<sub>eL</sub> N/mm<sup>2</sup></b>	<b>Elongation A<sub>5</sub> %</b>	<b>Impact strength ISO – V J +/- 0° C</b>
		510	> 420	> 22

<b>Weld metal analysis (typical. wt %)</b>	<b>C</b>	<b>Si</b>	<b>Mn</b>
	0.07	0.3	0.5

**Current** = - / ~ / 42 V

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

**Rebaking** 1 h. 100 °C +/- 10 °C (if necessary)

<b>Dia./Length</b>	<b>Amperage (A)</b>	<b>Pcs./packet</b>	<b>Pcs./carton</b>	<b>kg / 1000</b>	<b>kg / packet</b>	<b>kg / carton</b>
2.0 x 300	40 - 65	417	1250	9,9	4,0	12,0
2.5 x 350	65 - 85	281	843	17,8	5,0	15,0
3.2 x 350	95 - 145	166	497	30,2	5,0	15,0
4.0 x 350	125 - 210	112	336	44,7	5,0	15,0
5,0 x 450	180 - 240	67	200	90,0	6,0	18,0