

CARBO RR 6

International standards	EN 499	E 42 0 RR 12
	AWS A 5.1	E 6013

Approvals TÜV, DB, Ü

Typical applications and characteristics CARBO RR 6 is a thickly rutile coated electrode for welding seams with a particularly smooth surface and a self-removing slag. This field of application of this electrode is universal. Very easy weldability, excellent restriking, and a stable arc are only some of its outstanding characteristics. The weld-metal is crack-free.

Operating temperature From +/- 0 up to + 350 °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
Ship building steels A - B - D

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 +/- 0° C
520	> 420	> 22	> 47

Weld metal analysis
(typical. wt %)

C	Si	Mn
0.06	0.4	0.5

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
2.0 x 300	40 - 80	357	1428	11.2	4.0	16.0
2.5 x 350	60 - 110	200	800	21,5	4.3	17,2
3.2 x 350	80 - 140	125	500	36.0	4,5	18,0
4.0 x 350	120 - 200	80	320	70,0	5.6	22,4
4.0 x 450	120 - 200	87	348	69.0	6.0	24.0
5.0 x 450	160 - 280	53	212	112.7	6.0	24.0