

CARBO BR 10 D

International standards	EN 499	E 38 2 B 32 H10
	AWS A 5.1	E 7016

Approvals TÜV, DB, GL, Ü, UDT

Typical applications and characteristics CARBO BR 10 D is a double basic coated electrode of excellent welding characteristics combined with outstanding mechanical properties. Very well suitable for AC welding (also with small transformers). The double coating provides optimal welding characteristics even in constrained welding positions. Smooth weld aspect, free of penetration notches.

Operating temperature - 20 up to + 450 °C

Base materials

DIN EN 10025	S235JRG1, S235JRG2, S235JRG3, S275JR, 275J2G3, 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, ST 50-2
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

Ship building steels A/B/D/E ; A 32- D32 ; E 32 ; A 36 - D36 ; E 36

Mechanical properties of all-weld metal (typical values)	Tensile strength R_m N/mm ²	Yield strength R_{eL} N/mm ²	Elongation A₅ %	Impact strength ISO – V J - 40°C
	530	> 420	> 22	> 47

Weld metal analysis (typical, wt %)	C	Si	Mn
	0.07	0.4	0,7

Current = +/- / ~ / 42 V

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

Rebaking 1 h, 300 °C +/- 10 °C (if necessary)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	50 - 90	238	952	21.0	5,0	20,0
3.2 x 350	90 – 150	140	562	35.6	5,0	20,0
4.0 x 450	120 – 190	90	362	66,3	6,0	24,0
5.0 x 450	160 – 230	56	224	107.0	6,0	24,0