

CARBO NiMn B

International standards	AWS A 5.5	E 8018-C3 H4 R
	EN 499	E 46 6 1Ni B 4 2 H5

Approvals ---

Typical applications and characteristics CARBO NiMn B is a basic coated electrode for welding high-strength tempered steels as well AISI 4130 (similar 25CrMo4) as process welding on steels of corresponding strength. Due to its low hydrogen content (< 5ml / 100g), the weld metal is extremely crack-proof. Store in a dry place and rebake before use. Preheating and intermediate layer temperature acc. to the instructions of the base metal manufacturer.

Base materials S185 to S355; P235GH; ;P265GH; P295GH; S(P)275 to S(P)420; GP240R; Naxtra 56

Mechanical properties of all-weld metal (typical values)	Tensile strength R_m N/mm ²	Yield strength $R_{p0,2}$ N/mm ²	Elongation A_5 %	Impact energy ISO – V J		
				20°C	- 40°C	- 60°C
	600	520	25	150	120	65

Weld metal analysis (typical, wt %)	C	Si	Mn	Ni	Mo
	0,05	0,4	1,2	1	< 0,3

Current = +

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

Rebaking 1 h, 350 °C + / - 10 °C

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2.5 x 350	60 - 100	234	935	21.4	5.0	20.0
3.2 x 350	90 - 140	138	552	36.2	5.0	20.0
4.0 x 350	110 - 190	91	364	54.9	5.0	20.0
5.0 x 450	180 - 240	54	218	110.2	6.0	24.0

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