

niedriglegierte Stähle 1										
Typ / Kurzzeichen	Stabelektroden									
	E 42 0 RC 11	E 38 0 RC 11	E 42 0 RC 11	E 42 0 RC 11	E 42 0 RR 12	E 42 0 RR 73	E 38 2 RB 12	E 42 3 B 32 H10	E 42 4 B 32 H5	E 46 4 B 32 H5
Schweißzusatz	CARBO RC 3	CARBO RC 3 BLAU	CARBO RRC 5	CARBO RRC 6	CARBO RR 6	CARBO RR 11	CARBO RRB 7	CARBO BR 10 D	CARBO B 10	CARBO MN B
Grundwerkstoff										
1.0345	P235GH (H I)	●	●	●	●	●	●	●	●	●
1.0305	P235G1TH (St 35.8)	●	●	●	●	●	●	●	●	●
1.0037	S235JR (St 37-2)	●	●	●	●	●	●	●	●	●
1.0038	S235JRG2 (RSt 37.2)	●	●	●	●	●	●	●	●	●
1.0114	S235JO (St 37-3U)	●	●	●	●	●	●	●	●	●
1.0116	S235J2G3 (St 37-2)	●	●	●	●	●	●	●	●	●
1.0254	P235T1 (St 37.0)	●	●	●	●	●	●	●	●	●
1.0255	P235T2 (St 37.4)	●	●	●	●	●	●	●	●	●
1.0619	GP240GH (GS-C 25)	●	●	●	●	●	●	●	●	●
1.0457	L245NB (STE 240.7)	●	●	●	●	●	●	●	●	●
1.0418	L245MB	●	●	●	●	●	●	●	●	●
1.0111	P245NB	●	●	●	●	●	●	●	●	●
1.0461	S255N (StE 255)	●	●	●	●	●	●	●	●	●
1.0462	P255NH (WStE 255)	●	○	○	○	○	○	○	○	○
1.0463	S255NL (TStE 255)	○	○	○	○	○	○	○	○	○
1.1103	S255NL1 (EStE 255)								●	
1.0405	P255G1TH (St 45.8)	●	●	●	●	●	●	●	●	●
1.1101	S255NL (TTSt 35 N u. V)							●	●	●
1.0425	P256GH (H II)	●	●	●	●	●	●	●	●	●
1.0423	P265NB	●	●	●	●	●	●	●	●	●
1.0486	P275N (StE 285)	○	○	○	○	○	○	○	○	○
1.0487	P275NH (WStE 285)	○	○	○	○	○	○	○	○	○
1.0488	P275NL1 (TStE 285)	○	○	○	○	○	○	○	○	○
1.1104	P275NL2 (EStE 285)								●	
1.0256	P275T1 (St 44.0)	●	●	●	●	●	●	●	●	●
1.0257	P275T2 (St 44.4)	●	●	●	●	●	●	●	●	●
1.0044	S275JR (St 44-2)	●	●	●	●	●	●	●	●	●
1.0144	S275J2G3 (St 44-3N)	○	○	○	○	○	○	○	○	○
1.8818	S275M	○	○	○	○	○	○	○	○	○
1.8819	S275ML	○	○	○	○	○	○	○	○	○
1.0490	S275N (StE 285)	○	○	○	○	○	○	○	○	○
1.0491	S275NL (TStE 285)	○	○	○	○	○	○	○	○	○
1.0484	L290NB (StE 290.7), (X42)	●	●	●	●	●	●	●	●	●
1.0429	L290MB (StE 290.7 TM), (X42)	●	●	●	●	●	●	●	●	●
1.0050	E295 (St 50-2)							●	●	●
1.0481	P295GH (17 Mn 4)	●	●	●	●	●	●	●	●	●

● = geeigneter Schweißzusatz

○ = geeignete; Einsatztemperatur und Blechdicke beachten

niedriglegierte Stähle 2											
Typ / Kurzzeichen		Stabelektroden									
		E 42 0 RC 11	E 38 0 RC 11	E 42 0 RC 11	E 42 0 RC 11	E 42 0 RR 12	E 42 0 RR 73	E 38 2 RB 12	E 42 3 B 32 H10	E 42 4 B 32 H5	E 46 4 B 32 H5
Schweißzusatz		CARBO RC 3	CARBO RC 3 BLAU	CARBO RRC 5	CARBO RRC 6	CARBO RR 6	CARBO RR 11	CARBO RRB 7	CARBO BR 10 D	CARBO B 10	CARBO MN B
		Grundwerkstoff									
1.0482	P310GH (19 Mn 5)	○	○	○	○	●	○	●	●	●	●
1.0437	P310NB	●	●	●	●	●	●	●	●	●	●
1.0972	S315MC (QStE 300 TM)	○	○	○	○	○	○	○	○	○	○
1.0505	P315N (StE 315)	●	●	●	●	●	●	●	●	●	●
1.0506	P315NH (WStE 315)	●	○	○	○	●	○	○	●	●	●
1.0508	P315NL (TStE 315)	○	○	○	○	○	○	●	●	●	●
1.1105	S315NL1 (EStE 315)									●	
1.0060	E335 (St 60-2)								●	●	●
1.0473	P355GH (19 Mn 6)	○	○	○	○	●	○	●	●	●	●
1.8832	P355ML1 (TTStE 315 TM)							○	○	○	●
1.0557	P355NB	●	●	●	●	●	●	●	●	●	●
1.0565	P355NH (WStE 355)	○	○	○	○	●	○	●	●	●	●
1.0562	P355N (StE 355)	○	○	○	○	○	○	○	○	○	○
1.0566	P355NL1 (TStE 355)							○	○	○	●
1.8866	P355Q	○	○	○	○	○	○	○	○	○	○
1.8867	P355QH	○	○	○	○	○	○	○	○	○	○
1.8868	P355QL1								○	○	○
1.0421	P355T1 (St 52.0)	●	●	●	●	●	●	●	●	●	●
1.0581	P355T2 (St 52.4)	●	●	●	●	●	●	●	●	●	●
1.0570	S355J2G3 (St 52-3N)	●	●	●	●	●	●	●	●	●	●
1.8823	S355M (StE 355 TM)	○	○	○	○	○	○	○	○	○	○
1.0976	S355MC (QStE 355 TM)	○	○	○	○	○	○	○	○	○	○
1.8834	S355ML (TStE 355 TM)								○	○	○
1.0545	S355N (StE 355)	○	○	○	○	○	○	○	○	○	○
1.0546	S355NL (TStE 355)							○	○	○	○
1.1106	P355NL2 (EStE 355)									●	
1.0070	E360 (St 70-2)								●	●	●
1.0578	L360MB (StE 360.7 TM), (X52)	○	○	○	○	●	○	●	●	●	●
1.0582	L360NB (StE 360.7), (X52)	○	○	○	○	●	○	●	●	●	●
1.8948	L360QB (X52)	○	○	○	○	●	○	●	●	●	●
1.8947	L415QB (X60)									●	●
1.8972	L415NB (StE 415.7), (X60)									●	●
1.8973	L415NB (StE 415.7 TM), (X60)									●	●

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niedriglegierte Stähle 3											
Typ / Kurzzeichen		Stabelektroden									
		E 42 0 RC 11	E 38 0 RC 11	E 42 0 RC 11	E 42 0 RC 11	E 42 0 RR 12	E 42 0 RR 73	E 38 2 RB 12	E 42 3 B 32 H10	E 42 4 B 32 H5	E 46 4 B 32 H5
Schweißzusatz		CARBO RC 3	CARBO RC 3 BLAU	CARBO RRC 5	CARBO RRC 6	CARBO RR 6	CARBO RR 11	CARBO RRB 7	CARBO BR 10 D	CARBO B 10	CARBO MN B
		Grundwerkstoff									
1.0428	B420N (BST 420 S)	●	●	●	●			●	●	●	●
1.8824	P420M (FStE 420 TM)									●	●
1.8835	P420ML1 (FStE 420 TM)									●	●
1.8825	S420M (StE 420 TM)									●	●
1.0980	S420MC (QStE 420 TM)									●	●
1.8836	S420ML (TStE 420 TM)									○	○
1.8902	S420N (StE 420)									●	●
1.8932	P420NH (WStE 420)									●	○
1.8912	S420NL (TStE 420)									●	○
1.8913	S420NL1 (EStE 420)									●	○
1.8952	L450QB (X65)										●
1.8975	L450MB (StE 445.7 TM), (X65)										●
1.8826	P460M (FStE 460 TM)										●
1.8837	P460ML1 (FStE 460 TM)										●
1.8905	P460N (StE 460)										●
1.8935	P460NH (WStE 460)										●
1.8915	P460NL1 (TStE 460)										○
1.8870	P460Q										●
1.8871	P460QH										●
1.8872	P460QL1										○
1.8827	S460M (StE 460 TM)										●
1.0982	S460MC (QStE 460 TM)										●
1.8838	S460ML (TStE 460 TM)										○
1.8901	S460N (StE 460)										●
1.8903	S460NL (TStE 460)										○
1.8908	S460Q										●
1.8906	S460QL (TStE 460 V)										○
1.8916	S460QL1										○
1.0466	B500G3 (BSt 500 M)	●	●	●	●			●	●	●	●
1.0438	B500N (BSt 500 S)	●	●	●	●			●	●	●	●

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○ = geeignete; Einsatztemperatur und Blechdicke beachten

niedriglegierte Stähle 4										
Typ / Kurzzeichen	Stabelektroden									
	E 42 0 RC 11	E 38 0 RC 11	E 42 0 RC 11	E 42 0 RC 11	E 42 0 RR 12	E 42 0 RR 73	E 38 2 RB 12	E 42 3 B 32 H10	E 42 4 B 32 H5	E 46 4 B 32 H5
Schweißzusatz	CARBO RC 3	CARBO RC 3 BLAU	CARBO RRC 5	CARBO RRC 6	CARBO RR 6	CARBO RR 11	CARBO RRB 7	CARBO BR 10 D	CARBO B 10	CARBO MN B
Grundwerkstoff										
<b>Schiffbaustähle (Zuordnung entspr. GL)</b>										
	A / B / D	●		●		●			●	●
	E							●	●	
	A32 / D32	●						●	●	
	E32	●						●	●	
	A36 / D36							●	●	
	E36							●	●	
<b>Stahlguß nach DIN 17182</b>										
1.1131	GS-16 Mn 5 (G17Mn5)							●	●	●
1.1120	GS-20 Mn 5N/V (G20Mn5)							●	●	●
1.5015	GS-8 Mn 7 (G8Mn7)							●	●	●
1.6221	GS-8 Mn Mo 7 4							●	●	●
<b>Stahlguß nach DIN 1681</b>										
1.0420	GS-38							●	●	●
1.0446	GS-45							●	●	●
1.0552	GS-52							●	●	●
1.0558	GS-60							●	●	●
<b>Vergütungsstähle nach EN 10083</b>										
1.0402	C 22	●	●	●	●	●	●	●	●	●
1.0501	C 35								●	●
1.0503	C 45								●	●
1.0535	C 55								●	●
1.0601	C 60								●	●
1.1151	C22E (Ck 22)	●	●	●	●	●	●	●	●	●
1.1181	C35E (Ck 35)								●	●
1.1191	C45E (Ck 45)								●	●
1.1203	C55E (Ck 55)								●	●
1.1221	C60E (Ck 60)								●	●
1.1170	28Mn6								●	●

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