

## MIG-MAG Wires C-Mn and low-alloy steels

Carbofil 1 is a copper coated solid wire suitable for welding with CO<sub>2</sub> or 80% Ar-20% CO<sub>2</sub> shielding gases. Excellent mechanical properties.

Carbofil 1 is used for a wide range of structural steel applications. Good x-ray quality.

Classification	
AWS	A5.18: ER 70S-6
EN	440: G 42 4 M G3 Si1
EN	440: G 42 3 C G3 Si1

Approvals	Grades
DB	
GL	
LRS	
RINA	
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.08	1.50	0.90	≤ 0.025	≤ 0.025	-	-	-	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) -30°C	Hardness
As Welded	≥ 420	500-640	≥ 24	≥ 47	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

**Shielding Gas:** Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

### Materials

S(P)235 to S(P)355; GP240; GP280

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** K300 Kg. 16

Diameters	0,6	0,8	0,9	1,0	1,2	1,6