

CARBOFIL 1 GOLD

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

Carbofil 1 GOLD is a C-Mn solid wire with a special coating, suitable for welding with CO₂ or 80% Ar-20% CO₂ shielding gases.

It is used for a wide range of structural steel applications. Excellent mechanical properties and good x-ray quality.

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

Approvals	Grades
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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 ²	Tensile Strength N/mm ²	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	0,8	1,0	1,2			
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