

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

Carbofil TP is a copper coated solid wire suitable for the welding with CO₂ or mixed Ar/CO₂ shielding gases. Suited for structural work, earthmoving and construction site work. Suited for carbon-manganese steels. Developed for the TIME process welding.

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

Approvals	Grades
DB	
DNV	
LRS	
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	1.60	0.90	≤ 0.015	≤ 0.015	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -29°C	Hardness
As Welded	≥ 430	510-590	≥ 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

H I, H II, 17 Mn 4,

St 33, St 37, St 44, St 52-3, St E 255, St E 285, St E 315. St E 355, W St E 255, W St E 285,

St 45.8, St E 210.7, St E 240.7, St E 290.7, St E 320.7, St E 360.7

U St 37.0, St 37.0, St 37.4, St 44.0, St 44.4, St 52.0, St 52.4, St 35.8,

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 Kg. 16

Diameters	1,0	1,2				