

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

Carbofil 1A is a copper coated solid wire used with CO₂ or mixed Ar/CO₂ shielding gases. Suited for welding a wide range of structural steels, earthmoving and construction site work. Suitable for high strength carbon-manganese steels, types Fe 490 Fe 510.

| Classification | |
|----------------|----------------------|
| AWS | A5.18: ER 70S-6 |
| EN | 440: G 46 3 M G4 Si1 |

| Approvals | Grades |
|-----------|--------|
| ABS | |
| BV | |
| DB | |
| DNV | |
| GL | |
| LRS | |

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 |
|------|------|------|---------|---------|----|----|----|----|---|---|----|
| 0.06 | 1.70 | 0.90 | ≤ 0.020 | ≤ 0.030 | - | - | - | - | - | - | - |

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 | ≥ 460 | 550-630 | ≥ 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

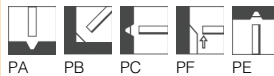
S(P)235 to S(P)460; GP240; GP280

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 Kg. 16

| | | | | | |
|-----------|-----|-----|-----|-----|--|
| Diameters | 0,8 | 1,0 | 1,2 | 1,6 | |
|-----------|-----|-----|-----|-----|--|