

# CARBOFIL 1A CF

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

Carbofil 1A CF is an uncoppered solid wire, suitable for welding with CO<sub>2</sub> or 80% Ar-20% CO<sub>2</sub> shielding gases. Excellent mechanical properties. CARBOFIL 1A CF is used for a wide range of structural steel applications.

Classification	
AWS	A5.18: ER 70S-6
EN	440: G 46 3 C G4 Si1
EN	440: G 46 4 M G4 Si1

Approvals	Grades

### 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 <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) -30°C	Hardness
As Welded	≥ 460	530-680	≥ 24	≥ 47	-

Gas test: Acc. To EN 439: M21(Arcal21-Atal6)

**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+				
				
PA	PB	PC	PF	PE

**Packaging data:** K300 Kg, 16

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