

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

Carbofil Galva is a copper coated solid wire used for the single pass GMAW welding, of galvanized sheets. Used with ternary shielding gas mixtures, such as ARCAL 14, to obtain spatter free welding with a good bead appearance. The use of this wire with a synergic inverter generator such as CITO@PULS, gives excellent results. After welding it is recommended to restore the protective surface in the welding area.

Classification

EN 440: G2 Ti

Approvals

Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.07	1.10	0.60	≤ 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) -20°C	Hardness
As Welded	≥ 480	≥ 570	≥ 22	≥ 90	-

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

Shielding Gas: Acc. To EN 439: M21(Arcal 21) or M14(Arcal 14)

Materials

S(P)235 to S(P)420

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 Kg. 16

Diameters	0,8	1,0	1,2			