

CARBOFIL CrMo 1

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

Carbofil CrMo1 is a copper coated solid wire suitable for welding 1,25% Cr 0,5% Mo steels. Excellent mechanical properties.

Carbofil CrMo1 can also be used for welding 0,9% Cr 0.5% Mo steels. Cold cracking resistant weld deposit.

Classification	
AWS	A5.28: ER 80S-G
EN	12070: G CrMo1 Si

Approvals	Grades
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	1.20	0.60	≤ 0.020	≤ 0.020	1.20	-	0.60	-	-	-	-

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
PWHT 690°C x 1h	≥ 355	≥ 550	≥ 20	≥ 80	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal 21-Atal 6)

Materials

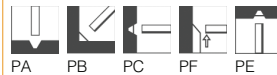
13CrMo4-5, 13CrMoSi5-5; G17CrMo5-5

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		
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