

MIG-MAG Wires High strength steels

Carbofil MnMo is a copper coated solid wire suitable for the welding of 0,5%Mo steels and high temperature resistant steels. Resistant to cold cracking and retains strength after prolonged heat treatment.

Classification	
AWS	A5.28: ER 80S-D2
EN	440: G 46 2 G4Mo

Approvals	Grades
DB	
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
0.09	1.90	0.60	≤ 0.020	≤ 0.020	-	0.15	0.50	-	-	-	-

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 620°C x 1h	≥ 460	530-680	≥ 22	≥ 47	-
As Welded	≥ 460	530-680	≥ 22	≥ 47	-

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

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

Materials

S(P)235-S(P)460, 16Mo3

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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