

## MIG-MAG Wires High strength steels

Carbofil NiMo1 is a copper coated alloyed Ni-Mo solid wire suitable for the MAG welding of high strength steels. Excellent mechanical properties. Low heat inputs are recommended to obtain optimum joint mechanical properties.

Classification	
AWS	A5.28: ER 100S-G
EN	12534: G 62 4 M Mn3Ni1Mo

Approvals	Grades
DB	

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	1.80	0.60	≤ 0.015	≤ 0.018	-	1	0.40	-	-	-	-

### 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) -40°C	Hardness
As Welded	≥ 620	700-890	≥ 18	≥ 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)460-S(P)620

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** K300 Kg. 16

Diameters	1,0	1,2	1,6			
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