

Carbofil NiMoCr is a copper coated solid wire used for the MAG welding of high tensile strength steels and type TI-HY100 steels. Excellent mechanical properties. Low heat inputs are recommended to obtain optimum joint mechanical properties.

Classification	
AWS	A5.28: ER 100 S-G
EN	12534:G 69 4 M Mn3Ni1CrMo

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
0.07	1.60	0.60	≤ 0.015	≤ 0.018	0.30	1.50	0.25	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -40°C	Hardness
As Welded	≥ 690	770 - 890	≥ 17	≥ 47	-

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

Shielding Gas: Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

Materials

S620, S690, HY 100

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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