

Carbofil Cu is a copper coated solid wire suitable for the welding of weathering steels such as COR-TEN. The mechanical properties allow Carbofil Cu to be used for joining high yield strength steels.

Classification	
AWS	A5.28: ER 80S-G
EN	12534: Mn3Ni1Cu (nearest)
EN	440: G 46 2 M (C) G0

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.10	1.40	0.80	≤ 0.020	≤ 0.030	-	0.60	-	-	-	-	0.40

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	≥ 460	550-650	≥ 24	≥ 60	-

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

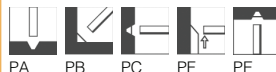
S235J0W; S235J2W; S355J0W; S355J2W; S355K2W

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 Kg, 16

Diameters	0,8	1,0	1,2			
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