

TIG Rods C-Mn steels and low-alloy steels

Carborod is a TIG rod suitable for welding mild and C-Mn steels; Carborod is generally used for the root pass and to support welding when no back pass is possible. Excellent mechanical and toughness properties for low temperature applications.

Classification	
AWS	A5.18: ER 70S-3
EN	1668: W 42 4 W2Si

Approvals	Grades
DNV	

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	0.65	≤ 0.025	≤ 0.025	-	-	-	-	-	-	-

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	≥ 420	500-640	≥ 20	≥ 47	-

Gas test: Acc. To EN 439: I1(Arcal1)

Shielding Gas: Acc. To EN 439: I1(Arcal1)

Materials

S(P)235 to S(P)355; GP240; GP280

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data: Tube 5 Kg

Diameters (L: 1000 mm)	1,0	1,2	1,6	2,0	2,4	3,2
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Further forms of delivery on request.