

CARBOROD Ni1

TIG Rods C-Mn steels and low-alloy steels

Carbofil Ni1 is a TIG rod suitable for welding low alloy, 1% Ni and fine grain steels for low temperature applications.

| Classification | |
|----------------|----------------------|
| AWS | A5.28: ER 80S-Ni1 |
| EN | 1668: W 46 6 M G3Ni1 |

| Approvals | Grades |
|-----------|--------|
| 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 |
|------|----|------|---------|---------|----|----|------|----|---|---|----|
| 0.08 | 1 | 0.60 | ≤ 0.020 | ≤ 0.020 | - | 1 | 0.10 | - | - | - | - |

All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength N/mm ² | Tensile Strength N/mm ² | Elongation A5 (%) | Impact Energy ISO - V (J) -60°C | Hardness |
|----------------|-------------------------------------|---------------------------------------|----------------------|---------------------------------------|----------|
| As Welded | ≥ 470 | 550-680 | ≥ 20 | ≥ 47 | - |

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

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

Materials

S(P)235-S(P)460, GP240-GP280

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data: Tube 5 Kg

| Diameters (L: 1000 mm) | 1,6 | 2,0 | 2,4 | 3,2 | | |
|------------------------|-----|-----|-----|-----|--|--|
| | | | | | | |

Further forms of delivery on request.