

TIG Rods C-Mn steels and low-alloy steels

Carborod NiMo1 is an alloyed Cr-Ni-Mo TIG rod suitable for welding high tensile strength steels such as TI -HY 80. Excellent mechanical properties. Low heat inputs are recommended to obtain optimum joint performance.

Classification

AWS	A5.18: ER 90S-G
EN	1668: W Mn3Ni1Mo

Approvals

Grades

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	≤ 0.15	1	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) -40°C	Hardness
As Welded	≥ 620	700-890	≥ 18	≥ 47	-

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

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

Materials

S(P)460-S(P)620

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data:

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

Further forms of delivery on request.