CARBOFIL 1A GOLD

TOP FEATURES

- Exceptional arc stability, minimal spatters and smooth bead profile
- Low presence of silicates
- Available in all packagings from spools to drums

TYPICAL APPLICATIONS

- General fabrication
- Heavy Fabrication
- Automotive
- Structural fabrication
- Robotics

CLASSIFICATION

AWS A5.18	ER70S-6
EN ISO 14341-A	G 46 4 M21 4Si1
	G 46 4 M20 4Si1
	G 46 3 C1 4Si1

APPROVALS

ABS, LR, DNV, TÜV, DB, CE

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO_2
M20	Mixed gas Ar+ 5-15% CO_2
C1	Active gas 100% CO_2

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S
0.08	1.7	0.9	≤0.025	≤0.025

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
						+20°C	-30°C	-40°C
Typical values	M21	AW	≥460	530-680	≥24	≥100	≥80	≥70
	M20	AW	≥460	530-680	≥24	≥100	≥80	≥70
	C1	AW	≥460	530-680	≥24	≥80	≥47	-

AW = As welded

- = not specified

AVAILABLE SIZES AND PACKAGING INFORMATION

Wire diameter (mm)	Packaging	Weight (kg)	Item number
0.8	SPOOL (B300)	16.0	G08K016P3E11
1.0	SPOOL (B300)	16.0	G10K016P3E11
	DRUM	300.0	G10D300E3E11
1.2	SPOOL (B300)	16.0	G12K016P3E11
	DRUM	300.0	G12D300E3E11
	DRUM	600.0	G12D600E3Z11
1.32	SPOOL (BS300)	16.0	G13L016PTE11
1.6	DRUM	500.0	G16D500ETV11