

CARBOROD 1A

TOP FEATURES

- Excellent mechanical and toughness properties for low temperature applications, down to -40°C.
- Smooth bead appearance
- Good feedability

TYPICAL APPLICATIONS

- General fabrication
- Construction

CLASSIFICATION

AWS A5.18 ER70S-6
EN ISO 636-A W 46 4 4Si1

SHIELDING GASES (ACC. EN ISO 14175)

I1 Inert gas Ar (100%)

APPROVALS

TÜV	CE
+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S
0.08	1.7	0.9	≤0.020	≤0.020

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						+20°C	-40°C
Typical values	I1	AW	≥460	550-680	≥24	≥120	≥47

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
1.6	PE Tube	5.0	T16T005R3S11
2.0	PE Tube	5.0	T20T005R3S11
2.4	PE Tube	5.0	T24T005R3S11
3.2	PE Tube	5.0	T32T005R3S11

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.