

CARBOFIL 1 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 42 4 M21 3Si1
	G 42 4 M20 3Si1
	G 42 3 C1 3Si1

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	1.4	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	-20°C	-40°C
Typical values	M21	AW	≥420	500-640	≥24	≥90	≥70	≥47
	M20	AW	≥420	500-640	≥23	≥90	≥70	≥47
	C1	AW	≥420	500-640	≥22	≥70	≥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	G08K016P6E11
	SPOOL (B300)	16.0	G10K016P6E11
1.0	DRUM	300.0	G10D300E6E11
	SPOOL (B300)	16.0	G12K016P6E11
1.2	SPOOL (B5300)	16.0	G12L016P6E11
	DRUM	300.0	G12D300E6E11
	DRUM	600.0	G12D600E6Z11