CARBOROD 1



TIG Rods C-Mn steels and low-alloy steels

CARBOROD 1 is a copper coated W3Si1/ER70S-6 type solid TIG welding rod. Suitable for use mainly with Ar shielding gas.

CARBOROD 1 is suitable for welding mild and C-Mn steels. and is generally used for the root pass and to support welding when no back pass is possible. Excellent mechanical and toughness properties for low temperature applications, down to -50°C.

Classification		
EN ISO	636-A: W 42 4 W3Si1	
AWS	A5.18: ER 70S-6	

Approvals	Grade
DB	•
TÜV	•

(6

Chemical analysis (Typical values in %)

C	Mn	Si	Р	S
0.08	1.5	0.9	≤ 0.025	≤ 0.025

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength	Tensile Strength	Elongation	Impact Energy ISO - V (J)	
neat Heatillellt	(MPa)	(MPa)	A5 (%)	+20 °C -50 °C	-50 °C
As Welded	≥ 420	500-640	≥ 24	≥ 90	≥ 47

Gas test: 100% Ar

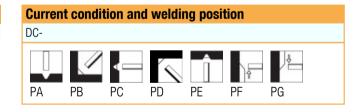
Shielding Gas - EN ISO 14175: I1

Materials

S(P)235 - S(P)420 GP240; GP280

Storage

Keep dry and avoid condensation



Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.2	TUB	5	•
1.6	TUB	5	•
2.0	TUB	5	•
2.4	TUB	5	•
3.2	TUB	5	•

