CARBOFIL 1A

TOP FEATURES

- Very consistent welding performance
- Optimal bead profile appearance and minimal spatters
- 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 3 C1 4Si1
	G 46 4 M21 4Si1

SHIELDING GASES (ACC. EN ISO 14175)

C1	Active gas 100% CO_2
M14	Mixed gas Ar+ 0.5-5% CO_2+ 0.5-3% O_2
M21	Mixed gas Ar+ >15-25% CO_2

APPROVALS

ABS	LR	DNV	TÜV	DB	CE
+	+	+	+	+	+

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
	C1	AW	≥460	530-680	≥24	≥80	≥47	

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)
0.8	SPOOL (B300)	16.0
	DRUM	300.0
1.0	SPOOL (B300)	16.0
	SPOOL (BS300)	16.0
	DRUM	300.0, 600.0
1.2	SPOOL (S300)	15.0
	SPOOL (B300)	16.0
	SPOOL (BS300)	16.0
	DRUM	300.0, 500.0, 600.0
1.6	SPOOL (B300)	16.0

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.