

CARBOFIL KV3

TOP FEATURES

- Very clean welding wire with guaranteed X<15 Bruscato factor, and with controlled As, Sb, Sn content against temper embrittlement.
- Ideal for the welding of creep resistant steels
- Also suitable for the welding of 1¼Cr 1Mo steels where improved resistance to hydrogen attack or corrosion by sulphur is required. Main applications are welding of boilers, plates and tubes as well as oil refineries e.g. in crack plants produced from mainly 10CrMo9-10 (ASTM A335 Gr. P/T22).

TYPICAL APPLICATIONS

- Petrochemical
- Nuclear Power generation

CLASSIFICATION

AWS A5.28 ER90S-B3
EN ISO 21952-B G 62M 2C1M

SHIELDING GASES (ACC. EN ISO 14175)

C1 Active gas 100% CO₂
M21 Mixed gas Ar+ >15-25% CO₂

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.075	0.55	0.57	0.005	0.005	2.5	0.1	1.0	0.1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20 °C
Typical values	M21	PWHT 620 °C x 1h	≥540	≥620	≥20	≥70

*PWHT = Post Welding Heat Treatment

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000283639

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.