

CARBOFIL GALVA is a copper coated G2Ti type solid MAG welding wire. Used with ternary shielding gas mixtures, such as ARCAL 14 (Ar+CO₂+O₂), to obtain spatter free welding with a good bead appearance.

CARBOFIL GALVA is a microalloyed steel wire, triple-deoxidised with Ti, Al and Zr, used to weld C-Mn and low-alloyed steels with light contamination or oxides on the surface, and for welding of galvanised steels with a tensile strength of 580 MPa, because of better fusion characteristics compared to standard unalloyed wires. Good low temperature toughness.

The use of CARBOFIL GALVA with a synergic inverter generator such as CITO@PULS (Oerlikon), gives excellent results. After welding it is recommended to restore the protective surface in the welding area.

Classification

EN ISO	14341-A: G 42 4 M21 2Ti
AWS	A5.18: ~ER 70S-2

Chemical analysis (Typical values in %)

	C	Mn	Si	P	S	Ti	Al	Zr
Wire	0.07	1.2	0.7	≤ 0.025	≤ 0.025	0.13	0.10	0.11
All weld metal (*)	0.07	1.1	0.7	≤0.025	≤0.025	-	-	-

(*) 82% Ar+18% CO₂

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-40 °C
As Welded	≥420	500-640	≥22	≥100	≥70

Gas test: 82% Ar+18% CO₂

Shielding Gas - EN ISO 14175 : M1, M2

Materials

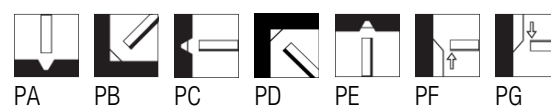
S(P)235 - S(P)420

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16
1.0	W000282849
1.2	W000282851