

## TIG Rods C-Mn steels and low-alloy steels

Carborod 1 is a TIG rod suitable for welding mild and C-Mn steels. Carborod 1 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.

Classification	
AWS	A5.18: ER 70S-6
EN	1668: W 42 4 W3Si1

Approvals	Grades
DB	
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.08	1.50	0.90	≤ 0.025	≤ 0.025	-	-	-	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) -50°C	Hardness
As Welded	≥ 420	500-640	≥ 20	≥ 47	-

Gas test: Acc. To EN 439: I1(Arcal1)

**Shielding Gas:** Acc. To EN 439: I1(Arcal1)

### Materials

S(P)235 to S(P)355; GP240; GP280

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC-



**Packaging data:** Tube 5 Kg

Diameters (L: 1000 mm)	1,0	1,2	1,6	2,0	2,4	3,2

Further forms of delivery on request.