

CARBOFIL 1a

Drôt pre zváranie MAG

Wire electrode for MAG-welding process

Druty do spawania metodą MAG



Standards:

DIN EN 440

DIN 8559

AWS/ASME SFA-5.18

Comparable No. of Materials:

G 50 4 M G4 Si 1

SG3 M2 Y 50 65

ER 70 S-6

1.5130

SK Vlastnosti a použitie:

Nízko legovaný zvärací drôt pre zváranie a naváranie metódou MAG konštrukčných ocelí v atmosfére CO₂ a zmiešaných plynov, napr. Inarc K 18. Dostupný aj ako CF (nepomedený) alebo GOLD (bronzovaný).

GB Applications and properties:

Low-alloy wire electrode for MAG-welding of structural and pipe steels, using CO₂ or mixed shielding gas. Available as CF (Copper Free) or GOLD (Bronzed).

POL Zastosowanie i własności:

Niskostopowy drut do spawania MAG stali konstrukcyjnych i rurowych, przy użyciu CO₂ lub mieszanki gazu osłonowego, np. Inarc K-18. Dostępny też w wersji CF (Copper Free – bez powłoki Cu) i jako GOLD (powłoka z brązu).

Materials for instance:

EN-Designation	DIN-Designation	EN-Designation	DIN-Designation
S235 to S355	St 37-2 to St 52-3	–	StE 285 to StE 460

Approvals:

TÜV, TÜV Austria, DB, ÖBB, Controlas, ABS, BV, DNV, GL, LRS

Analysis of wire electrode (typical values in %):

C	Si	Mn	P	S
0,06	0,90	1,70	≤0,020	≤0,030

Analysis of all-weld metal (typical values in %):

C	Si	Mn	P	S
0,06	0,80	1,30	≤0,025	≤0,025

Mechanical properties of all-weld metal (single values are typical values):

Heat treatment	Yield strength [N/mm ²]	Tensile strength [N/mm ²]	Elongation A ₅ [%]	Impact strength ISO-V [J]	
				+20 °C	-30 °C
AW	≥460	550–630	≥24	≥80	≥47

AW = as-welded

Analysis and mechanical properties apply to the use of shielding gas:

DIN EN 439-C1 (100 Vol.% CO₂)

Shielding gas acc. to DIN EN 439:

M21 (ARCAL 21)

Consumption:

12 l/min for Ø 0,8 mm, 15 l/min for Ø 1,2 mm

Form of delivery:

Wire cage reel K300 (15 kgs)				
Wire diameter [mm]	0,8	1,0	1,2	1,6

Further forms of delivery on request.

Type of current/Polarity/Welding positions:

