CARBOROD 1A



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TIG Rods Mild steels and low-alloy steels

CARBOROD 1A is a copper coated W4Si1/ER70S-6 type solid TIG welding rod depositing a C-1.5Mn weld metal. Suitable for use mainly with Ar shielding gas.

CARBOROD 1A is used for the welding of mild and C-Mn steels, requiring a yield strength <460MPa, with impact toughness properties down to -40°C.

Increased levels of manganese and silicon scavenge oxides and promote weld pool fluidity resulting in a superior weld bead appearance with an even contour finish.

Classification			
EN ISO	636-A: W 46 4 4Si1		
AWS	A5.18: ER 70S-6		

Chemical analysis (Typical values in %)

C	Mn	Si	Р	S
0.08	1.7	0.9	≤0.020	≤0.020

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength	Tensile Strength	Elongation	Impact Energy ISO - V (J)	
neat Heatillelit	(MPa)	(MPa)	A5 (%)	+20 °C	-40 °C
As Welded	≥ 460	550-680	≥ 24	≥ 120	≥ 47

Gas test: 100% Ar

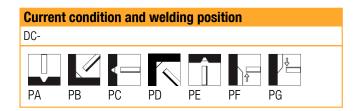
Shielding Gas - EN ISO 14175: I1

Materials

S(P)235 - S(P)460 GP240; GP280

Storage

Keep dry and avoid condensation



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