

## MIG-MAG Wires C-Mn and low-alloy steels

Carbofil Ni1 is a copper coated solid wire suitable for welding low alloyed 1% Ni steels and fine grain steels for low temperature applications.

Classification	
AWS	A5.28: ER 80S-Ni1
EN	440: G 46 6 M G3Ni1

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.08	1	0.60	≤ 0.020	≤ 0.020	-	1	0.10	-	-	-	-

### 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) -60°C	Hardness
As Welded	≥ 470	550-680	≥ 20	≥ 47	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

**Shielding Gas:** Acc. To EN 439: M21(Arcal 21-Atal 6)

### Materials

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

### Storage

Keep dry and avoid condensation.

### Current condition and welding position

DC+



**Packaging data:** K300 Kg. 16

Diameters	0,8	1,0	1,2			
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