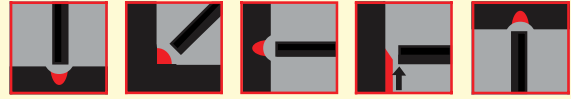


PRODUCT DATA SHEET

Oerlikon Carbofil I



Carbofil I is a copper coated solid wire suitable for welding with CO₂ or 80% Ar-20% CO₂ shielding gases. Excellent mechanical properties. Carbofil I is used for a wide range of structural steel applications. Good X-ray quality.

Storage

Keep dry and avoid condensation.

Classifications

AWS	A5.18	ER 70S-6
EN	14341	G 42 4 M G4Si1
EN	14341	G 42 3 C G4Si1

Approvals

DB
Germanischer Lloyd
Lloyds Register of Shipping
RINA
TÜV

Typical Chemical Analysis (All weld metal)

% Carbon	0,08	% Sulphur	≤0,025
% Manganese	1,5	% Phosphorous	≤0,025
% Silicon	0,9		

Typical Mechanical Properties (All weld metal using CO₂ gas)

Heat Treatment	As welded
Yield Strength N/mm ²	≥420
Tensile Strength N/mm ²	500 - 640
% Elongation on A5	≥24
Impact Energy at -30°C	≥47 J

Gas Test	CO ₂ or Afrox Fluxshield®
Shielding Gas	CO ₂ or Afrox Fluxshield®
Materials	S(P)235 to S(P)355; GP240; GP280

PRODUCT DATA SHEET

Packing Data

Diameter (mm)	Pack Mass Drums (kg)	Item Number
1,0	150,0	W122103
1,2	150,0	W122104
1,0	300,0	W122113
1,2	300,0	W122114
1,0	500,0	W122123
1,2	500,0	W122124

Packing Data K300

Diameter (mm)	Pack mass Spools (kg)	Item Number
0,8	15,0	W122001
0,9	15,0	W122002
1,0	15,0	W122003
1,2	15,0	W122004
1,6	15,0	W122005

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