

TIG Rods C-Mn steels and low-alloy steels

CARBOROD is a copper coated W2Si/ER70S-3 type solid TIG welding rod. Suitable for use mainly with Ar shielding gas.

CARBOROD is suitable for welding mild and C-Mn steels, 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, down to -40°C.

Classification	
EN ISO	636-A: W 42 4 W2Si
AWS	A5.18: ER 70S-3

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.07	1	0.65	≤ 0.025	≤ 0.025

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-40 °C
As Welded	≥ 420	500-640	≥ 20	≥ 90	≥ 47


Gas test: 100% Ar

Shielding Gas - EN ISO 14175 : I1

Materials

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

Storage
Keep dry and avoid condensation

Current condition and welding position
DC-

PA PB PC PE PF

Packaging data

Diam. (mm)	Length (mm)	Packaging Type	Weight (kg)	Code
1.2	1000	TUB	5	●
1.6	1000	TUB	5	●
2.0	1000	TUB	5	●
2.4	1000	TUB	5	●
3.2	1000	TUB	5	●