

TIG Rods C-Mn steels and low-alloy steels

CARBOROD MnMo is a copper coated ER 80S-D2 type solid TIG welding rod. Suitable for use mainly with Ar shielding gas.

CARBOROD MnMo is used for the welding of a range of carbon, low alloyed and higher strength steels in both the as welded and postweld heat-treated conditions.

CARBOROD MnMo contains molybdenum for increased deposit strength and a high level of deoxidizers (Mn and Si) to control porosity.

Classification	
EN ISO	21952-B: ~W 3M3 (closest)
AWS	A5.28: ER 80S-D2

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Mo
0.09	1.9	0.6	≤ 0.02	≤ 0.02	0.15	0.5

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-20 °C
620 °C x 1h	≥ 470	≥ 550	≥ 22	≥ 47


Gas test: 100% Ar

Shielding Gas - EN ISO 14175 : I1

Materials

S(P)235-S(P)460, 16Mo3

Storage
Keep dry and avoid condensation

Current condition and welding position
DC-

PA PB PC PE PF PG

Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.2	TUB	5	●