

TIG Rods C-Mn steels and low-alloy steels

CARBOROD 1 is a copper coated W3Si1/ER70S-6 type solid TIG welding rod. Suitable for use mainly with Ar shielding gas.

CARBOROD 1 is suitable for welding mild and C-Mn steels. and is 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 -50°C.

Classification	
EN ISO	636-A: W 42 4 W3Si1
AWS	A5.18: ER 70S-6

Approvals	Grade
DB	●
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.08	1.5	0.9	≤ 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	-50 °C
As Welded	≥ 420	500-640	≥ 24	≥ 90	≥ 47

Gas test: 100% Ar








Shielding Gas - EN ISO 14175 : I1

Materials

S(P)235 - S(P)420

GP240; GP280

Storage
Keep dry and avoid condensation

Current condition and welding position						
DC-						
						
PA	PB	PC	PD	PE	PF	PG

Packaging data

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