

## TIG Rods C-Mn steels and low-alloy steels

CARBOROD Mo is a copper coated WMoSi/ER70S-A1 type solid TIG welding rod depositing a C-0.8Mn0.5Mo weld metal. Suitable for use with Ar shielding gas.

CARBOROD Mo is used for welding low alloy creep resistant ferritic steels, used in chemical plant construction operating at elevated temperatures <500°C. Suitable for applications in petrochemical process plant where some resistance to hot hydrogen attack is necessary, and for welding of micro-alloyed steels where increased strength is required.

Classification	
EN ISO	21952-A: W Mo Si
AWS	A5.28: ER 70S-A1

Approvals	Grade
TÜV	●
CE	

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Mo
0.10	1.0	0.6	≤0.020	≤0.020	0.5

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-20 °C
As Welded	≥ 480	≥ 550	≥ 29	≥ 120	≥ 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-


### Packaging data

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