

CARBO S-NiMoCr CARBO T-NiMoCr

International standards

	S = solid wire	T = bare rod
AWS	ER 100 S-G (similar ER 100 S-2)	

Approvals

Application notes

Low alloyed steel MIG/TIG wire for welding quenched and subsequently drawn fine-grained structural steels.
The mechanical properties are subject to the kind of used inert gas. Best results are given with M 21
Preheating temperatures depend on the base material.

Operating temperature

-30° C up to +450° C / Interpass temperature should not exceed 200 °C

Base materials

St 50 – St 70
StE 51 – StE 60
N-A-XTRA 55-70

Mechanical properties of all-weld-metal with Gas: M 21 (typical values)

Tensile strength R _m N/mm ²	Yielding strength R _{p0,2} N/mm ²	Elongation A ₅ %	Impact strength ISO – V J
910	900	15	90

Weld metal analysis (typical, wt %)

C	Si	Mn	Ni	Mo	Cr	V
0,10	0,6	1,8	2,1	0,5	0,5	0,1

Gas types EN 439

S = solid wire	T = bare rod
M2, M3, M 11. M 21, M 23, M 32 Argon S1-S5	I1

Current

Diameter mm	= +			= -				
	0,8	1,0	1,2	1,6	2,0	2,4	3,2	4,0
Welding amps (A) min.	80	120	180					
(A) max.	130	190	250					

coils, weight

B300 15 kg. 25 kg.

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