

CARBO S-G 2

CARBO T-G 2

International standards

	S = massive wire	T = bare rod
Material Nr.	1.5125	
DIN 8559	SG 2 M2 Y 42 54	WSG 2 M2 Y 42 54
EN 440 (MSG)	G 3 Si 1	
EN 1668 (WIG)		W 3 Si 1
AWS A 5.7	ER70S-6	ER70S-6

Approvals

TÜV, DB, CE

Application notes

The MIG wire formula is intended for welding with mixed gases (See gas specification). For universal application in all positions for welding mild and low alloy steels.

Operating temperature

-40° C bis + 450° C

Base materials

DIN EN 10025 S235JRG1, S235JRG2, S235JRG3, S275JR, S275J2G3, S355J2G3, S420N
 DIN EN 10028-2 P235GH, P265GH, P295GH, P355GH
 DIN EN 10028-3 P275N, P275NH, P275NL2, P355N, P355NH, P355NL1
 DIN 17100 St 37-2, St 44-2, St 52-3,
 DIN 17175 St 35.8, St 45.8, 17 Mn 4, 19 Mn 5
 DIN 17102 StE 255 – StE 420, WStE 255 – WStE 420, TStE 255 – TStE 420
 DIN 17172 StE 210. 7 – StE 360.7 TM
 DIN 17155 H I, HII, 17 Mn 4, 19 Mn 6
 DIN 488 BSt 420S, BSt 500S, BSt 500M

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 at -40° C
580	>420	>22	>47

Weld metal analysis (typical, wt %)

C	Si	Mn
0,10	0,85	1,5

Gas types EN 439

S = massive wire
M2, M3, C1

T = bare rod
I1

Current

Diameter mm	= +				= -				
	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps (A) min.	80	120	180	250					
(A) max.	130	190	250	320					

coils, weight

B300 15 kg.

10 kg.

Rev. 002

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.