

# CARBO S-NiMoCr

# CARBO T-NiMoCr

## International standards

|                       | S = massive wire                | T = bare rod |
|-----------------------|---------------------------------|--------------|
| AWS<br>ASME SFA -5.28 | ER 100 S-G (similar ER 100 S-2) |              |

## Approvals

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## 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<br>R <sub>m</sub> N/mm <sup>2</sup> | Yielding strength<br>R <sub>p0,2</sub> N/mm <sup>2</sup> | Elongation<br>A <sub>5</sub> % | Impact strength<br>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 = massive wire**  
M2, M3, M 11. M 21, M 23, M 32  
Argon S1-S5

**T = bare rod**

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

Rev. 000

B300 15 kg.

25 kg.