

### Saffire Low Carbon Steel

EN 1668 W 42 3 WO (Tigrod)

#### Description and applications

Saffire Low Carbon Steel is a copper-coated low carbon double-deoxidised filler wire for TIG (with argon shielding gas) or oxy-acetylene (without flux) welding mild steels.

#### Composition

##### Wire Analysis Wt %

	Min	Max
C	0.07	0.12
Si	0.15	0.40
Mn	0.85	1.20
P		0.025
S		0.025
Cr		0.15
Ni		0.15
Cu		0.45

#### Mechanical Properties of weld Metal

##### All Weld Metal

Ar (I1)  
EN  
As welded

##### Properties

	Min	Max
ReL (MPa)	420	
Rm (MPa)	500	640
A4-A5 (%)	20	
Charpy V At -30°C (J)	47	