



CEWELD AA B Corten

TYPE	seamless basic slag flux cored wire for M21							
ANWENDUNGEN	Bridge-, general steel construction. Onshore and Offshore. General engineering. Heavy transportation and rail construction, etc.							
EIGENSCHAFTEN	AA B Corten is a seamless basic flux cored wire have a excellent weld puddle. This wire offers a unique welding deposit with more than 1% nickel and 0,5% Cu due to the seamless production process the hydrogen content is below HD<3ml/100g weld metal even after long storage.							
KLASSIFIKATION	AWS		A 5.29: E81T1-Ni1M-J H4					
GEEIGNET FÜR	CuNi, Reh ≤ 460MPa ISO 15608: 1.4 1.8963, 1.8946, 1.8965 S235JRG2Cu, S235J2G4Cu, S235J0Cu, S235JRW, S355J0Cu, S355J2G3Cu, S355J0W, 235J2W-S355J2W, S355K2W, WTSt 37, WTSt 52, ASTM A 588M Grade A,B, C...K, A 618 Gr. II; A 709 Gr. 50 WF3 CORten A, B, C, Patinax 37							
ZULASSUNGEN	CE							
SCHWEISSPOSITIONEN	 PA  PB  PC							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Cu
	0.05	0.7	1.5	0.015	0.015	0.5	1.1	0.5
MECHANISCHE GÜTEWERTE	Heat Treatment	RP0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness
					-40°C			
	As Welded	500	620	22	70			HRc
RÜCKTROCKNUNG	Not required							
GAS ACC. EN ISO 14175	M21							