



CEWELD AA M Corten

| TYPE | Seamless cored wire without slag for M21 | | | | | | | | | | | | | | | | |
|---|--|----------------|-------------------------|----------------------|------------------------------|-------------------------|--------------------|----------|-------------------------|-------|-----------|-----|-------|-------|-----|-----|-----|
| APPLICATIONS | Bridge-, general steel construction. Onshore and Offshore. General engineering. Heavy transportation and rail construction, etc. | | | | | | | | | | | | | | | | |
| PROPERTIES | CEWELD® AA M Corten is a seamless metal cored wire with remarkable stable arc and no spatters. Excellent for use in automated welding applications such as orbital Mag or robotic welding. This wire offers a unique welding deposit with more less than 1% nickel and 0,5% Cu to make it weather resistant. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage in unconditioned environment. | | | | | | | | | | | | | | | | |
| CLASSIFICATION | <table border="0"> <tr> <td>AWS</td> <td>A 5.28: E80C-W2 H4</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 46 6 Z M M21 1 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table> | AWS | A 5.28: E80C-W2 H4 | EN ISO | 17632-A: T 46 6 Z M M21 1 H5 | F-nr | 6 | FM | 1 | | | | | | | | |
| AWS | A 5.28: E80C-W2 H4 | | | | | | | | | | | | | | | | |
| EN ISO | 17632-A: T 46 6 Z M M21 1 H5 | | | | | | | | | | | | | | | | |
| F-nr | 6 | | | | | | | | | | | | | | | | |
| FM | 1 | | | | | | | | | | | | | | | | |
| SUITABLE FOR | <p>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</p> | | | | | | | | | | | | | | | | |
| APPROVALS | CE | | | | | | | | | | | | | | | | |
| WELDING POSITIONS | | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.7</td> <td>1.2</td> <td>0.015</td> <td>0.015</td> <td>0.5</td> <td>0.7</td> <td>0.5</td> </tr> </tbody> </table> | C | Si | Mn | P | S | Cr | Ni | Cu | 0.05 | 0.7 | 1.2 | 0.015 | 0.015 | 0.5 | 0.7 | 0.5 |
| C | Si | Mn | P | S | Cr | Ni | Cu | | | | | | | | | | |
| 0.05 | 0.7 | 1.2 | 0.015 | 0.015 | 0.5 | 0.7 | 0.5 | | | | | | | | | | |
| MECHANICAL PROPERTIES | <table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-20°C</th> <th>-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>510</td> <td>650</td> <td>22</td> <td>100</td> <td>70</td> <td>HRc</td> </tr> </tbody> </table> | Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | -20°C | -40°C | As Welded | 510 | 650 | 22 | 100 | 70 | HRc |
| Heat Treatment | R _{p0,2} (MPa) | | | | | R _m (MPa) | A ₅ (%) | | Impact Energy (J) ISO-V | | Hardness | | | | | | |
| | | -20°C | -40°C | | | | | | | | | | | | | | |
| As Welded | 510 | 650 | 22 | 100 | 70 | HRc | | | | | | | | | | | |
| REDRYING | Not required | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | M21 | | | | | | | | | | | | | | | | |



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AA M CORTEN 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-300 | 16 | 8720663405395 |