










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	AWS	A 5.28: E80C-W2 H4						
	AWS	A 5.36: E81T15-M21A4-W2-H4						
	EN ISO	17632-A: T 46 6 Z M M21 1 H5						
	F-nr	6						
	FM	1						
SUITABLE FOR	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							
APPROVALS	CE							
WELDING POSITIONS	<div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> <div> PE</div> <div> PF</div> <div> PG</div>							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Cu
	0.05	0.7	1.2	0.015	0.015	0.5	0.7	0.5
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V			
	As Welded /	510	650	22	-20°C		-40°C	
					100		70	
REDRYING TEMPERATURE	Not required							
GAS ACCORDING EN 14175	M21							



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AA M CORTEN 1,2MM

Type	KG/unit	EANCode
K-300	16	8720663405395