



CEWELD AA M Corten

TYPE Seamless metal cored wire for dC-WS welding of weather-resistant steels. (CuNi alloy, E80C-W2)

APPLICATIONS CEWELD® AA M Corten is a CuNi-alloyed, seamless metal powder cored wire for welding weather-resistant steels up to a yield strength of 460 MPa.

The main areas of application are

Bridge construction, general steel construction. Onshore and offshore. General mechanical engineering. Heavy transport and railway construction, landscaping and art, etc.

PROPERTIES CEWELD® AA M Corten has a remarkably stable arc without spatter. It is ideal for automated welding applications such as orbital mag or robotic welding. This wire offers a unique weld metal with less than 1 % nickel and 0.5 % Cu, which makes it weather resistant. Due to the continuous production process, the hydrogen content is below 3 ml/100 g of weld metal, even after prolonged storage in an 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 ≤ 460 MPa ISO 15608: 1.4
1.1845, 1.8946, 1.8958, 1.1861, 1.8963, , 1.8965, 1.1866, 1.1867, 1.1869,
S235JRG2Cu, S235J2G4Cu, S235J0Cu, S235JRW, S355J0Cu, S355J2G3Cu, S355J0W, 235J2W-
S355J2W, S355K2W, WTSt 37, WTSt 52,
Fe 360 C KI, Fe 360 D KI, Fe 510 C 1 KI, Fe 510 D 1 KI, Fe 510 C 2 KI, Fe 510 D 2 KI
ASTM A 588M Grade A,B, K, A 618 Gr. II; A 709 Gr. 50 WF3, A 242 Type 1
CORten A, B, C, Patinax 37, Weathering, DOCOL 355 W, DOMEX 355 W, Allwesta, DIWETEN...

APPROVALS

CE

WELDING POSITIONS



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	Rm MPa	A5 (%)	Impact Energy (J) ISO-V		
					-20°C	100	-40°C
	As Welded /	510	650	22			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