



CEWELD AAR Corten

TYPE Seamless microalloyed rutile flux-cored wire for weather-resistant steels.(E 81 T1, T 46 5)

APPLICATIONS CEWELD® AA R Corten is a CuNi-alloyed, seamless rutile flux-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-duty and railway construction, landscaping and

civil engineering, etc.

PROPERTIES CEWELD® AA R Corten has a remarkably stable arc that is virtually spatter-free. Ideal for automated

welding applications such as orbital magnet or robotic welding. This cored 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 a non-air-conditioned environment.

CLASSIFICATION AWS A 5.29: E81T1-GM H4

 Γ

0.05

AWS A 5.36: E81T1-M21A4-G-H4
EN ISO 17632-A: T 46 5 Z P M21 H5

F-nr 6 FM 1

SUITABLE FOR CuNi. Reh ≤ 460MPa 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,

0.7

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...

0.015

APPROVALS CE

WELDING POSITIONS



Mn

1.5

TYPICAL CHEMICAL ANALYSIS OF WELD METAL

(%)

ALL WELD MECHANICAL	_
PROPERTIES	

Heat	R _{P0,2}	Rm	A5	Impact Ener	rgy (J) ISO-V
Treatment	MPa	MPa	(%)	-50°C	-40°C
As Welded /	510	620	22	55	100

0.015

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M21

Cu

0.5

0.9





CEWELD AA R Corten

AA R CORTEN 1,2MM

Type	KG/unit	EANCode
BS-300	16	8720663405401