



# CEWELD AA R Corten

TYPE	Seamless micro-alloyed rutile flux-cored wire for M21.																
APPLICATIONS	Weather resistant steels, cranes, equipment, vessel and construction.																
PROPERTIES	Excellent weld puddle manipulation with fast freezing slag, superior out-of-position welding also at higher currents. Using temperature down to - 40 °C. Particularly suited for MAG-orbital welding and all-position welding on ceramic backing. Extreme low spatter loss, easy slag removal and hydrogen content below 3 ml/100gr. even after long unconditioned storage.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.29: E81T1-G H4</td> </tr> <tr> <td>AWS</td> <td>A 5.36: E81T1-M21A4-G-H4</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 46 5 Z P M21 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.29: E81T1-G H4	AWS	A 5.36: E81T1-M21A4-G-H4	EN ISO	17632-A: T 46 5 Z P M21 H5	F-nr	6	FM	1						
AWS	A 5.29: E81T1-G H4																
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	<p><b>CuNi, Reh ≤ 460MPa ISO 15608: 1.4</b>            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>1.5</td> <td>0.015</td> <td>0.015</td> <td>0.5</td> <td>1.2</td> <td>0.5</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Cu	0.05	0.7	1.5	0.015	0.015	0.5	1.2	0.5
C	Si	Mn	P	S	Cr	Ni	Cu										
0.05	0.7	1.5	0.015	0.015	0.5	1.2	0.5										
ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R<sub>P0,2</sub> MPa</th> <th>R<sub>m</sub> MPa</th> <th>A<sub>5</sub> (%)</th> <th>Impact Energy (J) ISO-V -50°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>510</td> <td>620</td> <td>22</td> <td>55</td> </tr> </tbody> </table>	Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V -50°C	As Welded /	510	620	22	55						
Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V -50°C													
As Welded /	510	620	22	55													
REDRYING TEMPERATURE	Not required																
GAS ACCORDING EN 14175	M21																



# CEWELD AA R Corten

AA R CORTEN 1,2MM

Type	KG/unit	EANCode
BS-300	16	8720663405401