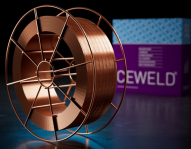




CEWELD SG Corten

TYPE	Copper coated wire for weather resistant (corten) steels.(ER 80S-G, Z2NiCu)														
APPLICATIONS	CEWELD® SG Corten is a copper-plated wire for the MIG/MAG process, produced with 0.8 % Ni / 0.4 % Cu weld metal, which has better corrosion resistance than mild steel in salt and sulphur-containing environments. It is primarily intended for welding weather-resistant steels such as Cor-Ten, but is also suitable for higher strength values and low temperatures in arts and crafts, bridges, ovens, decorative parts, steel structures, etc.														
PROPERTIES	CEWELD® SG Corten is extremely easy to weld with excellent welding properties. Weldable with Co2 and mixed gas. Thanks to the addition of Cu and Ni, this alloy offers outstanding weather-resistant properties with very good quality values.														
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.28: ER 80S-G</td> </tr> <tr> <td>EN ISO</td> <td>14341-A: G 42 2 M21 Z2NiCu</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.28: ER 80S-G	EN ISO	14341-A: G 42 2 M21 Z2NiCu	F-nr	6	FM	1						
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EN ISO	14341-A: G 42 2 M21 Z2NiCu														
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 THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Ni</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.09</td> <td>0.85</td> <td>1.4</td> <td>0.012</td> <td>0.015</td> <td>0.8</td> <td>0.45</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Ni	Cu	0.09	0.85	1.4	0.012	0.015	0.8	0.45
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0.09	0.85	1.4	0.012	0.015	0.8	0.45									
ALL WELD 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> </tr> <tr> <th>RT</th> <th>-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /1h</td> <td>480</td> <td>590</td> <td>24</td> <td>100</td> <td>50</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		RT	-40°C	As Welded /1h	480	590	24	100	50
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		RT	-40°C												
As Welded /1h	480	590	24	100	50										
REDRYING TEMPERATURE	Not required														
GAS ACCORDING EN 14175	M21														



CEWELD SG Corten

SG CORTEN 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663406224
D-200	5	8720663406217

SG CORTEN 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663406248
D-200	5	8720663406231