




CEWELD AA B Corten

TYPE	seamless basic slag flux cored wire for M21							
APPLICATIONS	Bridge-, general steel construction. Onshore and Offshore. General engineering. Heavy transportation and rail construction, etc.							
PROPERTIES	AA B Corten is a seamless basic flux cored wire have a excellent weld puddle. This wire offers a unique welding deposit with more than 1% nickel and 0,5% Cu due to the seamless production process the hydrogen content is below HD<3ml/100g weld metal even after long storage.							
CLASSIFICATION	AWS	A 5.29: E81T1-Ni1M-J H4						
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>							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Cu
	0.05	0.7	1.5	0.015	0.015	0.5	1.1	0.5
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V -40°C			
	As Welded /1h	500	620	22	70			
REDRYING TEMPERATURE	Not required							
GAS ACCORDING EN 14175	M21							