



# CEWELD AA M Corten

<b>TYPE</b>	Seamless cored wire without slag for M21							
<b>ANWENDUNGEN</b>	Bridge-, general steel construction. Onshore and Offshore. General engineering. Heavy transportation and rail construction, etc.							
<b>EIGENSCHAFTEN</b>	CEWELD® AA M Corten is a seamless metal cored wire with remarkable stable arc and no spatters. Excellent for use in automated welding applications such as orbital Mag or robotic welding. This wire offers a unique welding deposit with more less than 1% nickel and 0,5% Cu to make it weather resistant. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage in unconditioned environment.							
<b>KLASSIFIKATION</b>	AWS	A 5.28: E80C-W2 H4						
	EN ISO	17632-A: T 46 6 Z M M21 1 H5						
	F-nr	6						
	FM	1						
<b>GEEIGNET FÜR</b>	<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							
<b>ZULASSUNGEN</b>	CE							
<b>SCHWEISSPOSITIONEN</b>								
<b>TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)</b>	C	Si	Mn	P	S	Cr	Ni	Cu
	0.05	0.7	1.2	0.015	0.015	0.5	0.7	0.5
<b>MECHANISCHE GÜTEWERTE</b>	Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	
	As Welded	510	650	22	-20°C	-40°C	HRc	
					100	70		
<b>RÜCKTROCKNUNG</b>	Not required							
<b>GAS ACC. EN ISO 14175</b>	M21							



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AA M CORTEN 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405395