



# 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**



**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

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-40°C		
As Welded	500	620	22	70		HRC

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21