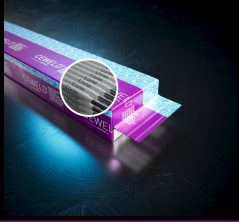


CEWELD E Corten

TYPE	Cu and Ni alloyed basic electrode for welding weather-resistant steels with yield strength of about 460 MPa.					
APPLICATIONS	CEWELD® E Corten is a basic electrode for weather resistant steel. Suitable for welding of weathering steels, containing about 0,5% of Cu. Mainly used for Corten steel structures in civil constructions as for bridges, pylons, security components, structural constructions, artwork, bridges etc.					
PROPERTIES	CEWELD® E Corten are producing a low alloyed weld deposit. Suitable for positional welds except vertical down, spatter free, stable arc, regular fusion and easy deslagging. Excellent mechanical properties and well suited for use at sub zero temperatures.					
CLASSIFICATION	AWS	A 5.5: E 8018-W2				
	EN ISO	2560-A: E 46 2 Z B 42 H5				
	W.Nr.	1.8962				
	F-nr	4				
	FM	1				
SUITABLE FOR	CuNi, Reh ≤ 460MPa ISO 15608: 1.4 1.1845, 1.8946, 1.8958, 1.1861, 1.8963, , 1.8965, 1.1866, 1.1867, 1.1869, S235JRG2Cu, S235J2G4Cu, S235J0Cu, S235JRW, S355J0Cu, S355J2G3Cu, S355J0W, 235J2W-S355J2W, S355K2W, WTSt 37, WTSt 52, Fe 360 C KI, Fe 360 D KI, Fe 510 C 1 KI, Fe 510 D 1 KI, Fe 510 C 2 KI, Fe 510 D 2 KI ASTM A 588M Grade A,B, K, A 618 Gr. II; A 709 Gr. 50 WF3, A 242 Type 1 CORten A, B, C, Patinax 37, Weathering, DOCOL 355 W, DOMEX 355 W, Allwesta, DIWETEN...					
APPROVALS	CE					
WELDING POSITIONS	 PA  PB  PC  PE  PF					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Cu
	0.07	0.7	1.05	0.55	0.5	0.45
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V -20°C	Hardness
	As Welded	540	650	22	75	HRc
REDRYING	400°C / 1 hr					
CURRENT TYPE:	DC+					
GAS ACC. EN ISO 14175						



CEWELD E Corten

E CORTEN 2,5 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682051016

E CORTEN 3,2 X 450MM

Packaging	KG/unit	EanCode
Vacuum	3,0	8720682051023

E CORTEN 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	4,0	8720663400703