



# 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                                | <b>CuNi, Reh ≤ 460MPa ISO 15608: 1.4</b><br>1.1845, 1.8946, 1.8958, 1.1861, 1.8963,, 1.8965, 1.1866, 1.1867, 1.1869,<br>S235JRG2Cu, S235J2G4Cu, S235J0Cu, S235JRW, S355J0Cu, S355J2G3Cu, S355J0W, 235J2W-<br>S355J2W, S355K2W, WTSt 37, WTSt 52,<br>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<br>ASTM A 588M Grade A,B, K, A 618 Gr. II; A 709 Gr. 50 WF3, A 242 Type 1<br>CORten A, B, C, Patinax 37, Weathering, DOCOL 355 W, DOMEX 355 W, Allwesta, DIWETEN... |                         |          |        |                         |     |     |         |
| 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     |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | RP0,2 (MPa)             | Rm (MPa) | A5 (%) | Impact Energy (J) ISO-V |     |     | Hardnes |
|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                         |          |        | -40°C                   |     |     |         |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 500                     | 620      | 22     | 70                      |     |     | HRc     |
| REDRYING                                    | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                         |          |        |                         |     |     |         |
| GAS ACC. EN ISO 14175                       | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         |          |        |                         |     |     |         |