



# CEWELD SG Corten Tig

**TYPE** Copper coated welding wire developed for TIG welding of weather resistant steels.

**APPLICATIONS** Weather resistant steels, art constructions, bridges, ovens, deco parts etc.

**PROPERTIES** Due to the addition of 0,5% copper and 0,8% Ni this alloy offers excellent weather resistant properties

**CLASSIFICATION**

AWS	A 5.28: ER 80S-G
EN ISO	636-A: W 42 4 Z2NiCu
F-nr	6
FM	1

**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 THE FILLER METAL (%)**

C	Si	Mn	P	S	Ni	Cu
0.08	0.6	1.3	0.015	0.015	0.8	0.4

**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	460	570	22	55	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD SG Corten Tig

SG CORTEN TIG 1,6 X  
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663406279

SG CORTEN TIG 2,0 X  
1000MM

Packaging	KG/unit	EanCode
Tube	2,5	8720663406286

SG CORTEN TIG 2,4 X  
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663406293

SG CORTEN TIG 3,2 X  
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663406309