



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 the 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 pool. 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**
 1.8963, 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 | 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 | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | -20°C | | |
| 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 |