



# CEWELD AA M Corten

TYPE	Seamless cored wire without slag for M21																
APPLICATIONS	Bridge-, general steel construction. Onshore and Offshore. General engineering. Heavy transportation and rail construction, etc.																
PROPERTIES	CEWELD® AA M Corten is a seamless metal cored wire with remarkable stable arc and no spatters. Excellent for use in automated welding applications such as orbital Mag or robotic welding. This wire offers a unique welding deposit with more less than 1% nickel and 0,5% Cu to make it weather resistant. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage in unconditioned environment.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.28: E80C-W2 H4</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 46 6 Z M M21 1 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.28: E80C-W2 H4	EN ISO	17632-A: T 46 6 Z M M21 1 H5	F-nr	6	FM	1								
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SUITABLE FOR	<p><b>CuNi, Reh ≤ 460MPa Iso 15608: 1.4</b>            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</p>																
APPROVALS	CE																
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.7</td> <td>1.2</td> <td>0.015</td> <td>0.015</td> <td>0.5</td> <td>0.7</td> <td>0.5</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Cu	0.05	0.7	1.2	0.015	0.015	0.5	0.7	0.5
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		-20°C	-40°C														
As Welded	510	650	22	100	70	HRc											
REDRYING	Not required																
GAS ACC. EN ISO 14175	M21																



# CEWELD AA M Corten

AA M CORTEN 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405395