

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



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Cu
0.07	0.7	1.05	0.55	0.5	0.45

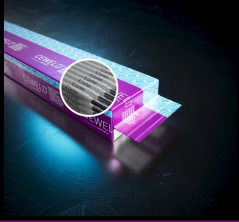
MECHANICAL PROPERTIES

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