CEWELD AA R Corten

certilas® THE FILLER METAL SPECIALIST

TYPE

Seamless microalloyed rutile flux-cored wire for weather-resistant steels.(E 81 T1, T 46 5)

APPLICATIONS

CEWELD® AA R Corten is a CuNi-alloyed, seamless rutile flux-cored wire for welding weather-resistant steels up to a yield strength of 460 MPa.
The main areas of application are bridge construction, general steel construction. Onshore and offshore. General mechanical engineering. Heavy-duty and railway construction, landscaping and civil engineering, etc.

PROPERTIES

CEWELD® AA R Corten has a remarkably stable arc that is virtually spatter-free. Ideal for automated welding applications such as orbital magnet or robotic welding. This cored wire offers a unique weld metal with less than 1 % nickel and 0.5 % Cu, which makes it weather resistant. Due to the continuous production process, the hydrogen content is below 3 ml/100 g of weld metal, even after prolonged storage in a non-air-conditioned environment.

CLASSIFICATION

AWS	A 5.29: E81T1-GM H4, A 5.36: E81T1-M21A4-G-H4
EN ISO	17632-A: T 46 5 Z P M21 H5
F-nr	6
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	P	S	Cr	Ni	Cu
0.05	0.7	1.5	0.015	0.015	0.5	0.9	0.5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-50°C	-40°C	
As Welded	510	620	22	55	100	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M21

CEWELD AA R Corten

AA R CORTEN 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663405401