



CEWELD SG Corten

TYPE Mag welding wire for weather resistant (corten) steels.

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

PROPERTIES Extreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. Weldable with Co2 and Mix gas. Due to the addition of 0,5% Cu this alloy offers excelent weather resistant properties.

CLASSIFICATION

AWS	A 5.28: ER 80S-G
EN ISO	14341-A: G 42 2 M21 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 (%)

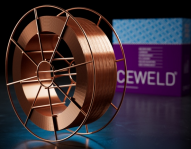
C	Si	Mn	P	S	Ni	Cu
0.09	0.85	1.4	0.012	0.015	0.8	0.45

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V	
				RT	-40°C
As Welded /1h	480	590	24	100	50

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M21



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SG CORTEN 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663406224
D-200	5	8720663406217

SG CORTEN 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663406248
D-200	5	8720663406231
Drum		8720663406255

SG CORTEN 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663406262