

## E Corten

**CATEGORY** SMAW Stick Electrodes

**TYPE** Cu and Ni alloyed basic electrode for welding weather-resistant steels with yield strength of about 460 N/mm<sup>2</sup>.

**PROPERTIES** Basic electrode for weather resistant steel such as, Patinax, Corten, Acor 50, HSB 51, etc. Excellent mechanical properties and well suited for use at sub zero temperatures.

**CLASSIFICATION**

AWS	A 5.5: E 7018-G
EN ISO	2560-A: E 46 4 ZB 42 H5
DIN: W.Nr.	1.8962
DIN	8529: EY 50 75 CuNiB

**SUITABLE FOR** Weather resistant steels, WTSt 37, WTSt 52, Corten A, B, C, Patinax 37, RBH 35, Acor 37, Acor 50, HSB 51, HSB 55 C, 1.8962, 1.8963, 1.8965, 1.8960

**APPROVALS** CE approved

**WELDING POSITIONS:**



**ALL WELD METAL WEIGHT%**

C	Mn	Si	Cu	Ni	Mo
0.06	1.0	0.50	0.40	0.70	

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>460	540-620	>20	>47	>47		

AW: as welded

**WELDING PARAMETERS PACKING**

D (mm)	Welding Parameters		Packing	
	Length (mm)	Current (A)	kg / can	kg / 6pack
2.5	300	65-90	2.0	12
3.2	350	110-140	2.4	14.4
4.0	450	140-180	4.0	24

**REDRYING TEMPERATURE** 400°C/1hr