

SA Corten

CATEGORY SAW Arc Submerged

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

PROPERTIES Submerged arc welding wire for weather resistant steels such as Corten and Patinax to resist long term corrosion against weather influences. SA Corten wire can be used with FL188 (or an other type depending on the requirements and application).

CLASSIFICATION

AWS	A.5.28: EG
EN ISO	14171-A: S2NiCu1
DIN	8557: S2NiCu1

SUITABLE FOR S235J2G3 Cu, S355J2G3 Cu, S235JRW, S355JRW, S235J2W, S355J2W, CORTEN, PATINAX 37, ALCODUR 50, KORALPIN 52

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cu	Ni
0.09	1.40	0.85	0.45	0.85

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		Packing
	Voltage (V)	Current (A)	kg (K-415)
1.6			25
2.0			25
2.4			25
3.2			25
4.0			25