

SG Corten

CATEGORY	GMAW-GTAW Solid wires
TYPE	Copper coated welding wire developed for MAG welding of weather resistant 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% copper this alloy offers excelent weather resistant properties.

CLASSIFICATION	AWS	A.5.28: ER 80 S-G
	EN ISO	14341-A: G 42 2 M/C GO
	DIN	8575: SG NiCu

SUITABLE FOR	S235J2G3 Cu, S355J2G3 Cu, S235JRW, S355JRW, S235J2W, S355J2W, CORTEN, PATINAX 37, ALCODUR 50, KORALPIN 52, 1.8962, 1.8963
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APPROVALS	CE approved
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WELDING POSITIONS:	
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WELD METAL ANALYSIS %					
C	Mn	Si	Cu	Ni	Mo
0.09	1.40	0.85	0.45	0.85	

MECHANICAL PROPERTIES					
Shield gas	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V	
				+20°C	-40°C
C1	> 450	> 570	> 26	> 90	
M21	> 480	> 590	> 24	> 100	> 50

WELDING PARAMETERS / PACKING					
Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
0.8		60-200	KD-300 / Drum / B3	15 / 250 / 300	1080 / 1000 / 600
1.0		80-300	KD-300 / Drum / B3	15 / 250 / 300	1080 / 1000 / 600
1.2		120-380	KD-300 / Drum / B3	15 / 250 / 300	1080 / 1000 / 600

REDRYING TEMPERATURE	Not required
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GAS ACC. EN ISO 14175:	M21, C1
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