

SG Corten Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Copper coated welding wire developed for TIG welding of weather resistant steels.

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

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

APPROVALS CE approved

WELDING POSITIONS:



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)	A ₅ (%)	Impact Energy (J) ISO-V	
				+20°C	-40°C
C1	> 450	> 570	> 26	> 90	
M21	> 480	> 590	> 24	> 100	> 50

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing
	Voltage (V)	Current (A)	kg
1.6 x 1000 mm			5
2.0 x 1000 mm			5
2.4 x 1000 mm			5
3.2 x 1000 mm			5

REDRYING TEMPERATURE Not required