

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/mm².

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 _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	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	kg / 1000
2.5	300	65-90	2.0	15	19.8
3.2	350	110-140	2.4	14.4	36.4
4.0	450	140-180	4.0	24	66.7

REDRYING TEMPERATURE 400°C/1hr