

## AA R Corten

**CATEGORY** FCAW Flux-Cored

**TYPE** Seamless micro-alloyed rutile flux-cored wire for CO2 and M21.

**APPLICATIONS** Weather resistant steels, cranes, equipment, vessel and construction.

**PROPERTIES** Excellent weld puddle manipulation with fast freezing slag, superior out-of-position welding also at higher currents. Using temperature down to - 40 °C (- 40 °F) . Particularly suited for MAG-orbital welding and all-position welding on ceramic backing. Extreme low spatter loss, easy slag removal and hydrogen content below 3 ml/100gr. even after long unconditioned storage.

**CLASSIFICATION**

AWS	5.29: E81T1M H4
	5.29M: E551-T1M H4
EN ISO	17632-A: T 46 2 ZPM1 H5

**SUITABLE FOR** Weather resistant steels, WSt 37, WSt 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, ASTM A 618

**APPROVALS** CE approved

**WELDING POSITIONS:**



**ALL WELD METAL WEIGHT %**

C	Mn	Si	P	S	Ni	Cu
0.05	1.30	0.50	<0.015	<0.015	1.20	0.5

**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	530-680	>22	>47			

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	type spool / drum	kg / spool / drum	kg / pallet
1.0	19-25	140-230	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600
1.2	21-29	160-280	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600
1.6	23-32	190-350	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600

**REDRYING TEMPERATURE** Not required

**GAS ACC. EN ISO 14175:** M21, C1