

CATEGORY	GMAW(-C) Metalcored Wires
TYPE	Seamless cored wire without slag for M21
APPLICATIONS	Bridge-, general steel construction. Onshore and Offshore. General engineering. Heavy transportation and rail construction, etc.
PROPERTIES	CEWELD® AA M Corten is a seamless metal cored wire with remarkable stable arc and no spatters. Excellent for use in automated welding applications such as orbital Mag or robotic welding. This wire offers a unique welding deposit with more less than 1% nickel and 0,5% Cu to make it weather resistant. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage in unconditioned environment.

CLASSIFICATION	AWS	A 5.28: E80C-W2 H4
	AWS	A 5.36: E81T15-M21A4-W2-H4
	EN ISO	17632-A: T 46 5 Z M M21 1 H5
	F-nr	6
	FM	1

SUITABLE FOR	CuNi, Reh ≤ 460MPa ISO 15608: 1.4 1.8963, 1.8946, 1.8965 S235JRG2Cu, S235J2G4Cu, S235J0Cu, S235JRW, S355J0Cu, S355J2G3Cu, S355J0W, 235J2W-S355J2W, S355K2W, WTSt 37, WTSt 52, ASTM A 588M Grade A,B, C...K, A 618 Gr. II; A 709 Gr. 50 WF3 CORten A, B, C, Patinax 37
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APPROVALS	CE
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TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)							
C	Si	Mn	P	S	Cr	Ni	Cu
0.05	0.7	1.2	0.015	0.015	0.5	0.7	0.5

ALL WELD MECHANICAL PROPERTIES						
Heat Treatment	R _{p0,2}	R _m	A ₅	Impact Energy (J) ISO-V		
	MPa	MPa	(%)	-20°C		-40°C
As Welded /	510	650	22	100		70

WELDING PARAMETERS / PACKING						
PARAMETERS	PARAMETERS	PARAMETERS	PACKING	PACKING	PACKING	
D (MM)	VOLTAGE (V)	CURRENT (A) DC+	SPOOLS / DRUMS	KG / SPOOLS	KG PER PALLET	
1,2 MM	14-31	90-330	D-200 / KD-300 / POP	5 / 16 / 300	1200 - 1024 - 600	

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175	M21
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