



CEWELD SG Corten

TYPE	Copper coated wire for for weather resistant (corten) steels.(ER 80S-G, Z2NiCu)						
APPLICATIONS	CEWELD® SG Corten is a copper-plated wire for the MIG/MAG process, produced with 0.8 % Ni / 0.4 % Cu weld metal, which has better corrosion resistance than mild steel in salt and sulphur-containing environments. It is primarily intended for welding weather-resistant steels such as Cor-Ten, but is also suitable for higher strength values and low temperatures in arts and crafts, bridges, ovens, decorative parts, steel structures, etc.						
PROPERTIES	CEWELD® SG Corten is extremely easy to weld with excellent welding properties. Weldable with Co2 and mixed gas. Thanks to the addition of Cu and Ni, this alloy offers outstanding weather-resistant properties with very good quality values.						
CLASSIFICATION	AWS	A 5.28: ER 80S-G					
	EN ISO	14341-A: G 46 4 M21 Z 3Ni1Cu					
	F-nr	6					
	FM	1					
SUITABLE FOR	CuNi, Reh ≤ 460MPa ISo 15608: 1.4 1.1845, 1.8946, 1.8958, 1.1861, 1.8963, , 1.8965, 1.1866, 1.1867, 1.1869, S235JRG2Cu, S235J2G4Cu, S235J0Cu, S235JRW, S355J0Cu, S355J2G3Cu, S355J0W, 235J2W-S355J2W, S355K2W, WTSt 37, WTSt 52, Fe 360 D KI, Fe 360 D KI, Fe 510 C 1 KI, Fe 510 D 1 KI, Fe 510 C 2 KI, Fe 510 D 2 KI ASTM A 588M Grade A,B, K, A 618 Gr. II; A 709 Gr. 50 WF3, A 242 Type 1 CORten A, B, C, Patinax 37, Weathering, DOCOL 355 W, DOMEX 355 W, Allwesta, DIWETEN...						
APPROVALS	CE						
WELDING POSITIONS	PAPBPCPDPEPFPG						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Ni	Cu
	0.09	0.85	1.4	0.012	0.015	0.8	0.45
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
					RT	-40°C	
	As Welded	480	590	24	100	50	HRc
REDRYING	Not required						
GAS ACC. EN ISO 14175	M21						



CEWELD SG Corten

SG CORTEN 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663406224
D-200	5	8720663406217

SG CORTEN 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663406248
D-200	5	8720663406231