



# CEWELD AA M Corten

**TYPE** Seamless metal cored wire for dC-WS welding of weather-resistant steels. (CuNi alloy, E80C-W2)

**APPLICATIONS** CEWELD® AA M Corten is a CuNi-alloyed, seamless metal powder cored wire for welding weather-resistant steels up to a yield strength of 460 MPa.  
The main areas of application are  
Bridge construction, general steel construction. Onshore and offshore. General mechanical engineering. Heavy transport and railway construction, landscaping and art, etc.

**PROPERTIES** CEWELD® AA M Corten has a remarkably stable arc without spatter. It is ideal for automated welding applications such as orbital mag or robotic welding. This wire offers a unique weld metal with less than 1 % nickel and 0.5 % Cu, which makes it weather resistant. Due to the continuous production process, the hydrogen content is below 3 ml/100 g of weld metal, even after prolonged storage in an unconditioned environment.

**CLASSIFICATION**

|        |                                                |
|--------|------------------------------------------------|
| AWS    | A 5.28: E80C-W2 H4, A 5.36: E81T15-M21A4-W2-H4 |
| EN ISO | 17632-A: T 46 6 Z M M21 1 H5                   |
| 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 C 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

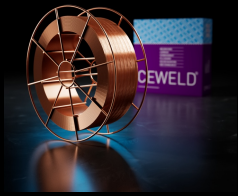
**WELDING POSITIONS**

| 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 |

| MECHANICAL PROPERTIES | Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       | Hardness |
|-----------------------|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
|                       |                |                         |                      |                    | -20°C                   | -40°C |          |
|                       | As Welded      | 510                     | 650                  | 22                 | 100                     | 70    | HRC      |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD AA M Corten

AA M CORTEN 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-300     | 16      | 8720663405395 |