



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 _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	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



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AA M CORTEN 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405395