



CEWELD SG Corten Tig

TYPE Copper coated welding wire developed for TIG welding of weather resistant steels.

APPLICATIONS Weather resistant steels, art constructions, bridges, ovens, deco parts etc.

PROPERTIES Due to the addition of 0,5% copper and 0,8% Ni this alloy offers excellent weather resistant properties

CLASSIFICATION

AWS	A 5.28: ER 80S-G
EN ISO	636-A: W 42 4 Z2NiCu
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

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

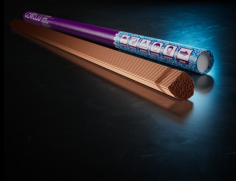
C	Si	Mn	P	S	Ni	Cu
0.08	0.6	1.3	0.015	0.015	0.8	0.4

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				-40°C	
As Welded	460	570	22	55	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 I1



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SG CORTEN TIG 1,6 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663406279

SG CORTEN TIG 2,0 X
1000MM

Packaging	KG/unit	EanCode
Tube	2,5	8720663406286

SG CORTEN TIG 2,4 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663406293

SG CORTEN TIG 3,2 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663406309