



# CEWELD E Corten

**TYPE** Cu and Ni alloyed basic electrode for welding weather-resistant steels with yield strength of about 460 MPa.

**APPLICATIONS** CEWELD® E Corten is a basic electrode for weather resistant steel. Suitable for the welding of weathering steels, containing about 0,5% of Cu. Mainly used for Corten steel structures in civil constructions as for bridges, pylons, security components, structural constructions, artwork, bridges etc.

**PROPERTIES** CEWELD® E Corten are producing a low alloyed weld pool. Suitable for positional welds except vertical down, spatter free, stable arc, regular fusion and easy deslagging. Excellent mechanical properties and well suited for use at sub zero temperatures.

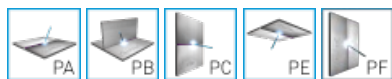
**CLASSIFICATION**

AWS	A 5.5: E 8018-W2
EN ISO	2560-A: E 46 2 Z B 42 H5
W.Nr.	1.8962
F-nr	4
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 WELD METAL (%)**

C	Si	Mn	Cr	Ni	Cu
0.07	0.7	1.05	0.55	0.5	0.45

**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	
As Welded	540	650	22	75	HRc

**REDRYING** 400°C / 1 hr

**CURRENT TYPE:** DC+

**GAS ACC.** EN ISO 14175



# CEWELD E Corten

E CORTEN 2,5 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682051016

E CORTEN 3,2 X 450MM

Packaging	KG/unit	EanCode
Vacuum	3,0	8720682051023

E CORTEN 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	4,0	8720663400703