

AA R Corten

CATEGORY FCAW Flux-Cored

TYPE Seamless micro-alloyed rutile flux-cored wire for CO2 and M21.

APPLICATIONS Weather resistant steels, cranes, equipment, vessel and construction.

PROPERTIES Excellent weld puddle manipulation with fast freezing slag, superior out-of-position welding also at higher currents. Using temperature down to - 40 °C (- 40 °F) . Particularly suited for MAG-orbital welding and all-position welding on ceramic backing. Extreme low spatter loss, easy slag removal and hydrogen content below 3 ml/100gr. even after long unconditioned storage.

CLASSIFICATION AWS 5.29: E81T1M H4
5.29M: E551-T1M H4
EN ISO 17632-A: T 46 2 ZPM1 H5

SUITABLE FOR Weather resistant steels, WTSt 37, WTSt 52, Corten A, B, C, Patinax 37, RBH 35, Acor 37, Acor 50, HSB 51, HSB 55 C, 1.8962, 1.8963, 1.8965, 1.8960, ASTM A 618

APPROVALS CE approved

WELDING POSITIONS:



ALL WELD METAL WEIGHT %

C	Mn	Si	P	S	Ni	Cu
0.05	1.30	0.50	<0.015	<0.015	1.1	0.45

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>460	530-680	>22	>47			

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	type spool / drum	kg / spool / drum	kg / pallet
1,2	21-29	160-280	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600

REDRYING TEMPERATURE Not required

GAS ACC. EN ISO 14175: M21, C1