

# EZ - SG CORTEN

## CLASSIFICATION

EN ISO 14341-A	AWS / ASME SFA-5.28
G 42 2 C/M 0	ER80S-G

## DESCRIPTION AND APPLICATION

A copper or bronze coated solid wire alloyed with nickel and copper. It is used for welding of atmospheric corrosion resistant steels (COR-TEN A, COR-TEN B). It is also suitable for welding of mild and low-alloy steels with tensile strength up to 590 N/mm<sup>2</sup>. Shielding atmosphere C1 (CO<sub>2</sub>) or M21 (Ar/CO<sub>2</sub>).

Steel grade	HRN	DIN (W. Nr.)	HRN / EN / ISO
Constructional steels	Č 0261 do Č 0545	St 33 (1.0035) do St 52-2N (1.0050) COR-TEN A, B, C; Patinax 37	S 185 do E 295 Fe 310-0 do Fe 490-2
Boiler steels	Č 1202 Č 1204 Č 3133 Č 3105	HI (1.0345) HII (1.0425) 17Mn4 (1.0481) 19Mn6 (1.0473)	P235GH P265GH P295GH P355GH
Tube and pipe steels	Č 1212 do Č 3100	St 35.4 (1.0309) do St 52.4 (1.0581) StE 210.7 (1.0307) do StE 360.7 (1.0582)	DX55D do P355T2 L210 do L360NB
Shipbuilding steels	A, B, D, E AH 32 do EH 36	A, B, D, E AH 32 do EH 36	
Fine-grained steels	ČRO 250 do ČRO 350 ČRV 250 do ČRV 350	StE 285 (1.0486) StE 355 (1.0562) WStE 285 (1.0487) WStE 355 (1.0565)	P275N P355N P275NH P355NH
Cast steels	ČL 0300 do ČL 0500	GS-38 (1.0416) do GS-52 (1.0551)	C18D do S355JRC

## MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R <sub>eL</sub> N/mm <sup>2</sup>	R <sub>m</sub> N/mm <sup>2</sup>	A <sub>5</sub> %	KV (-20°C) J
> 430	540 - 640	> 20	≥ 47

## APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

	C	Si	Mn	Ni	Cu
%	0,06 - 0,10	0,7 - 0,9	1,4 - 1,5	0,5 - 0,8	0,3 - 0,5

## SHIELDING GAS

C1 ili M21

## PACKAGING

Wire diameter mm	Winding
1,0; 1,2	precision-wound (S-S)
15 kg - metal spool (S-S)	

## APPROVALS

DB; TÜV

