



SELECTARC TIG F75

Old reference : TIG CORTEN

Classification

AWS A5.28 : ER80S-G

EN 125334

: W Z Mn3Ni1Cu

Characteristics

GTAW- copper coated rod with a steel deposit containing Cu- Ni- Cr, for welding all steels resistant to atmospheric corrosion (industrial, sea, rural). Steels with improved resistance to atmospheric corrosion

Applications

Public buildings, Department of civil engineering, Navy, Tanks, Water tower, Bridges, Crash barrier, Electrical pylons.

Base Materials

UNS	DIN	EN	Mat. N°
	WT St37-2	S 255 JOW	1.8958
	WT St37-3	S 235 J2W	1.8961
K 11538 ; K 11541 ; K 12032	WT St52-3	S355 J2G1W	1.8963

Trademarks - COR-TEN A,B,C, PATINAX INDATEN ACOR

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Cu	S	P	Fe
0.08	0.80	1.40	0.40	0.80	0.40	0.015	0.012	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg A ₅	Impact (KV)	
	R _m (MPa)	R _{p0.2} (MPa)		Temp.°C	J
AW	620	530	26	- 20	90

Welding Current & Instructions

Welding Mode	Shielding Gas
TIG = -	Ar : 6 - 12 l/min Back shielding : N ₂ /H ₂ : 3 - 6 l/min

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