



SELECTARC UP CORTEN

Weather Resistant Solid SAW Wire

Classification

AWS A5.23 : EG

Characteristics

Copper coated wire for submerged arc welding (SAW) alloyed with Cu- Ni- Cr, for welding all steels resistant to atmospheric corrosion (industrial, sea, rural). Regular fusion, Good removal of the slag. Smooth & uniform weld seams.

Applications

Public buildings, Department of Civil Engineering, Navy, Tanks, Water tower, Bridges, Crash barrier, Electrical Pylons. Steels with improved resistance to atmospheric corrosion.

Base Materials

NF A 35 - 502	E24W Quality 2 to 4 , E36W A2-A4
DIN	WT St37-2, WT St37-3 , WT St52
Trade Marks	COR-TEN A,B,C - PATINAX - INDATEN - ACOR..

Typical Wire Composition (%)

C	Si	Mn	Cr	Ni	Cu	P	S	Fe
0.10	0.20	1.40	0.40	0.80	0.40	0.018	0.012	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R _m (MPa)	YS R _{p0.2} (MPa)	% Elg A ₅	Impact (kJ)	
				Temp. °C	J
AW	630	500	25	- 20	75
				- 40	50

Welding Current & Instructions

Ø (mm)	Polarity	Current (A)	Voltage (V)	Stick out (mm)	Flux
2.4	= +	200 - 400	28 - 32	~ 24	UP LA 04
3.2	= +	300 - 500	28 - 32	~ 32	
4.0	= +	500 - 700	29 - 33	~ 40	

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. Fumes: Consult information on MSDS, available upon request.