

NAME OF PRODUCT: MasterWeld Corten(ER80S-G) **CLASSIFICATION:** SFA-AWS A5.28 ER80S-G
NiCu TIG wire EN ISO 14341-A- G 50 4 C1/M21 Z3Ni1

TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

| Rm (N/mm ²) | Rs (N/mm ²) | Al% 5d | Kv + 20°C J | Kv - 40 °C J | HARDNESS HB | HARDNESS HRC |
|----------------------------|----------------------------|--------|----------------|-----------------|----------------|-----------------|
| 630 | 550 | 22 | | 60 | | |

The mechanical characteristics are indicative and could change by the heat of the material, shielding gas, welding parameters and other factors.

CHEMICAL COMPOSITION (average)

| C % | Si % | Mn% | P % | S % | Cu % | Cr % | Ni % | Mo % | Al % | V % | Zr+Ti% |
|-------|------|------|--------|--------|--------|------|------|--------|--------|--------|--------|
| 0,080 | 0,80 | 1,40 | <0,020 | <0,020 | < 0,40 | 0,25 | 0,80 | < 0,05 | <0,020 | <0,030 | < 0,15 |

Cu including copper coating.

WELDING PROCESS

| | |
|----------------------|---|
| Shielding gas | MIG: EN ISO 14175 C1, M20, M21, M33 and similar |
| Current and Polarity | MIG: DC+ |
| Welding Position | EN ISO 6947: PA, PB, PC, PD, PE, PF, PG |

APPROXIMATE WELDING PARAMETERS OF THE WIRE

| ∅ (mm) | 0,80 | 1,00 | 1,20 |
|----------|----------|-----------|-----------|
| A | 80 - 160 | 150 - 250 | 220 - 320 |
| V | 18 - 22 | 22 - 28 | 26 - 32 |

DIMENSIONS

| MIG (mm) | 0,80 | 0,90 | 1,00 | 1,14 | 1,20 | 1,40 | 1,60 |
|----------|------|------|------|------|------|------|------|
| | | | | | | | |

Other sizes on request.

Tolerance and technical supplying condition according to EN ISO 544 and AWS

CERTIFICATE: EN 10204 - 3.1 (Chemical Analysis) / EN 10204 - 2.2 (Mechanical Characteristics)

IDENTIFICATION: External and internal label
Stamping on each tig rod

STORAGE: Refer to the technical instruction for the handling and the storage of consumables

APPROVALS: C E Marking according to EN 13479

BASE MATERIALS

| Standard | Type |
|----------|------------------------------------|
| | S235JRW, S235J2G3 |
| | Patinax 37, Alcodur50, Korlpin 52, |
| | S355J2G3Cu, 9CrNiCuP3-2-4 |
| | Corten A - B1 |
| | Itacor |
| | WTsT52.3, S355K2W |

APPLICATIONS

Excellent resistance to atmospherical agents thanks to the presence of Cu, Cr, Ni.
Suitable for bridges, cranes, ground moving machines, boilers, building structures, petrolchemical sector, fans, gas pipes, fume suction, etc.

SPECIAL FINISHING