

Lastofil 11017

Welding of Corten steel

CLASSIFICATION

EN ISO 14341-A : G 50 4 C1/M21 Z3Ni1

AWS A5.28 : ER 80S-G

GENERAL DESCRIPTION

Solid wire suitable for welding weather resistant structural steels like Cortensteel and other high strength low-alloy steels. The wire is alloyed with copper and nickel which gives a high resistance against atmospheric corrosion. Suitable for working temperatures from -30 °C to 350 °C (-20 °F to 660 °F).

APPLICATIONS

Architectural applications, but also where weather resistant steel is used because of its higher strength (steel chimneys, railway wagons, bridges etc).

Welding of Corten A and B.

Patinox.

Weatherproof structural steel S235J0W, S235J2W, S355J2W.

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : 0.06 - 0.09	Si : 0.60 - 0.90	Mn : 1.40 - 1.50	Ni : 0.70 - 0.90	Cu : < 0.45
Cr : 0.20 - 0.35				

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 500 MPa	≥ 610 MPa	≥ 18%	≥ 47 J (-40°C)

GENERAL INFORMATION

Welding positions All

Shielding gas Ar/CO₂, M21 (EN ISO 14175)

Packing 15 kg spool (in a cardboard box)

Polarity DC+

Diameter (mm) 0.8 1.0 1.2

Tips & tricks

Clean and degrease the weld area.

When welding in open air protect the weld area against the wind.

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.