

EVO-COR 1,0x18KG CORTEN MIG LANKA ER80S-G



Tuote

Tuotekoodi: EVOCOR1018
Viivakoodi: 8837000000004

Tekniset tiedot

Paino: 1 kg

COR

LOW ALLOYED WELDING WIRES

SFA-AWS A5.28 ER80S-G

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

EN ISO 636-A- W Z3Ni1

Average Chemical analysis

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

The copper value include the surface coating

Typical mechanical properties of all-weld metal

Rm	Rs	Al	Kv
N/mm ²	N/mm ²	%5d	-40°C
630	550	22	60 J

The mechanical properties are approximate and may range on the basis of the Heat, shielding gas, welding parameters and other factors

Welding process

Protection	MIG: EN ISO 14175 C1, M20, M21, M33 and similar / TIG: I1 (Argon)
Current and polarity	MIG: DC+ / TIG: DC-
Welding positions	EN ISO 6947: PA, PB, PC, PD, PE, PF, PG
Post Welding Heat Treatment	as welded

Dimensions

MIG (mm)	0,60 - 0,80 - 0,90 - 1,00 - 1,14 - 1,20 - 1,40 - 1,60
TIG (mm)	1,00 - 1,20 - 1,60 - 2,00 - 2,40 - 3,00 - 3,20 - 4,00

BASE MATERIALS TO BE WELDED

S235JRW, S235J2G3 ; Patinax 37, Alcodur50, Koralpin 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, petrochemical sector, fans, gas pipes, fume suction, etc.

APPROVALS

Contact ITALFIL

