MIG F75

Old reference: MIG CORTEN

Classification

AWS A5.28 : ER80S-G ISO 14341-A : G Z Mn3Ni1Cu

Description & Applications

Copper coated solid wire low alloyed with Nickel, Chromium and Copper for gas (Ar + CO_2) metal arc welding of astmospheric corrosion resistant steels.

Main applications: Public equipment and constructions, shipbuilding...

Base materials

Atmospheric corrosion resistant steels:

UNS	*DIN*	*EN*	*Mat. N°*
K 12032	WT St37-2	S255 JOW	1.8958
K 11541	WT St37-3	S235 J2W	1.8961
K 11538	WT St52-3	S355 J2G1W	1.8963
Trademarks: COR-TEN A,B,C – PATINAX – INDATEN – ACOR			

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S
Min									
Max	Not specified								
Type	0.08	0.75	1.4	0.30	0.70	0.01	0.40	0.010	0.010

All Weld Metal Mechanical Properties

	R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	500	560	18	-40°C	>47
Max		720			
Type	530	620	26	-40°C	70

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	1.0 1.2	80 - 260 100 - 360	17 - 32 18 - 34	ISO 14175: M21 (Ar/CO_2) 12-15 l/min

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