



WELDING

UP Corten

Classification

AWS A5.23 : EG

ISO 14171-A : S2Ni1Cu

Description & Applications

Copper coated solid wire low alloyed with Nickel, Chromium and Copper for submerged arc welding of atmospheric 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	Fe
Min	0.08	0.15	0.70		0.65		0.40			
Max	0.12	0.35	1.20	0.40	0.90	0.15	0.65	0.020	0.020	Rem.
Type	0.10	0.25	1.0	0.20	0.80	0.01	0.45	0.015	0.010	Rem.

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters				Flux
		Current (A)	Voltage (V)	Stick out (mm)	Speed (cm/min)	
SAW =+	2.4	200 - 400	25 - 30	18	40 - 60	UP LA04
	3.2	300 - 500	28 - 32	20	40 - 60	
	4.0	500 - 700	30 - 35	22	50 - 60	

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