

<b>International standards</b>	EN 499	E 46 5 Z B 32
	AWS A 5.1	E8018-G

**Approvals** -----

**Typical applications and characteristics** CARBO Corten is a basic coated electrode for welding weathering resistant construction steels. This type of alloy is slowly reacting whenever corrosion occurs. Therefore the deposits are resistant to atmospheric corrosion and seawater. The electrode is used for steel constructions, welding of bridges.

**Operating temperature** From -30° C up to +450° C

**Base materials** S235J2W (WTSt 37-3) bis S355J2G1W (WTSt 52-3), (Patinax, CORTEN, Dillicor) u. a.

**Mechanical properties of all-weld metal**  
( typical values )

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{eL}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Impact strength ISO – V J - 50°C
580	> 460	> 22	> 47

**Weld metal analysis**  
( typical, wt %)

C	Si	Mn	Cu	Ni
0.06	0,4	1.0	0,4	0,6

**Current** = + / ~ , 65 V

**Welding positions** PA, PB, PC, PD, PE, PF,

**Rebaking** 1 h, 350° C +/- 10° C ( if necessary)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg / 1000	kg / packet	kg / carton
2.5 x 350	70 – 110	234	935	21,4	5.0	20.0
3.2 x 350	100 – 150	138	552	36,2	5.0	20.0
4.0 x 450	130 – 200	85	340	70,8	6,0	24.0
5,0 x 450	190 – 280	54	218	110,2	6,0	24,0

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