



## ULTRACORTEN III

LOW ALLOY STEEL (Weathering Steel)



Low alloy steel Electrode for welding weathering steels.

**CLASSIFICATION : EN ISO 2560-A**

**AWS A/SFA 5.5**

**APPROVALS :**

E 46 2 Z B 32

E 8018-W2

ABS

### KEY FEATURES :

- Basic type iron powder electrode
- Cr-Ni-Cu type low alloy steel welds
- High crack resistance under restraint
- Radiographic quality weld deposit
- Exhibits excellent atmospheric corrosion resistance compared to normal steels
- All position capability

### WELDING POSITION :



**AC (70 OCV) / DCEP**

### TYPICAL APPLICATIONS :

- Welding of weathering steels e.g. CORTEN-A and CORTEN-B and their equivalents
- Bridges, Architectural structures, Exhaust gas flues, Chimneys
- Suitable for ASTM A36, A283 Gr.B/C

**REDRYING CONDITION : 250-300°C for minimum 1 hr. (Also available in vacuum packed condition)**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>
Typical	0.06	1.0	0.6	0.5
Specification	0.12 max	0.50 - 1.30	0.35-0.80	0.45-0.70
	<b>Ni</b>	<b>Cu</b>	<b>S</b>	<b>P</b>
Typical	0.7	0.6	0.02	0.02
Specification	0.40-0.80	0.30-0.75	0.03 max.	0.03 max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>	<b>CVN Impact at -20°C, J</b>
Typical	As Welded	605	520	22	66
Specification		550 min	460 min	19 min	50-100

**Diffusible H2 Content: <5 ml/100 gm)**

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Approx. Pcs/Carton</b>	<b>Carton/Box</b>	<b>Approx. wt. of 1000 pcs, Kg.</b>
3.15 x 450	100-140	113	4	44
4.0 x 450	140-180	79	4	63
5.0 x 450	190-250	49	4	102