



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 % :

	C	Mn	Si	Cr
Typical	0.06	1.0	0.6	0.5
Specification	0.10 max.	0.60-1.30	0.35-0.80	0.45-0.70
	Ni	Cu	S	P
Typical	0.7	0.6	0.02	0.02
Specification	0.40-0.80	0.30-0.75	0.03 max.	0.04 max.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -20°C, J
Typical	As Welded	605	520	22	66
Specification		560-660	480-570	19-26	50-100

Diffusible H2 Content: <5 ml/100 gm)

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
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

