

## ER 80S-G (Corten)

Low Alloy WIRE/GMAW

## Standards

EN/ISO-Standard - 14341-A

AWS-Standard - A5.28

EN/ISO-Classification - G 50 4 C1/M21 Z3Ni1

AWS-Classification - ER 80S-G

## Features and Applications

- Solid wire suitable for welding weather resistant structural steels like corten and other high strength low-alloy steels.
- Alloyed with copper and nickel which gives a high resistance against atmospheric corrosion.
- This wire provides a unique aesthetic appeal and can be identified by its typically reddish rust or patina look for structural and artistic applications.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on the construction of containers, tanks, bridges, building panels, chimneys, means of transport, offshore platforms etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



## Typical Base Materials

S235JRW, S235J2G3 ; Patinax 37, Alcodur50, Koralpin 52, ; S355J2G3Cu, 9CrNiCuP3-2-4 ; Corten A - B1 ; TsT52.3, S355K2W\*

\* Illustrative, not exhaustive list

## Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

## Shielding Gases

EN ISO 14175 - C1, M20, M21, M33

## Polarity

DC (+)

## Welding Parameters

Ø mm	0.80	1.00	1.20
Current (A)	80-160	150-250	220-320
Voltage (V)	18-22	22-28	26-32

## Mechanical Properties (Typical)

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
630	550	22	60	-40°C

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

## Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu % <sup>a</sup>	Cr %	Ni %	Mo %	Al %	V %	Zr + Ti %
0.08	0.80	1.40	<0.020	<0.020	<0.40	0.25	0.80	<0.05	<0.020	<0.030	<0.15

<sup>a</sup> (includes copper coating)

## Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
6011100488	0.80	15	D300 PLW	72
6011100489	1.00	15	D300 PLW	72
6011100490	1.20	15	D300 PLW	72

**Liability:** Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.

