



ULTRACORTEN III

LOW ALLOY WEATHERING STEEL ELECTRODE

AWS A/SFA 5.5 **E8018-W2**

CLASSIFICATION:

EN ISO 2560-A
E 46 2 Z B 32 H5

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

APPROVALS: CE

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

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


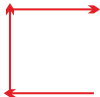
C	Mn	Si	Ni	Cr	Cu
0.04	1.0	0.6	0.5	0.5	0.5

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	460	22	66
Specification		550 min	520 min	19 min	47 min

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	60-90	 AC (70 OCV) / DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 450	100-140		
4.0 x 450	140-180		
5.0 x 450	190-250		

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing