

## XP ER 80S-G (CORTEN)

WEATHERING STEEL



### CLASSIFICATIONS

<b>EN ISO 636-A</b>	<b>AWS A5.28</b>
W Z3Ni1	ER80S-G

### KEY FEATURES AND APPLICATIONS

- Low-alloyed solid wire specifically designed for welding weathering steels (like COR-TEN).
- Provides a minimum yield strength of 500 MPa.
- Offers superior corrosion resistance in atmospheric environments due to the presence of Ni Cu.
- Excellent mechanical properties at subfreezing temperatures down to -40°C.
- Widely used in the construction of bridges, building panels, chimneys, railway gantries and offshore platforms.

### BASE MATERIALS

S235JRG2Cu, S235J2G4Cu, S235J0Cu, S235JRW, S355J0Cu, S355J2G3Cu, S355J0W, 235J2W-S355J2W, S355K2W

ASTM A 588 Gr. A, B, C, K; A 618 Gr. II; 709 Gr. C

### CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Ni	Cr	Mo	V	Cu	Al	Ti + Zr
MIN	0.06	0.70	1.30	-	-	0.70	0.20	-	-	0.25	-	-
MAX	0.10	1.30	1.50	0.020	0.020	1.00	0.40	0.15	0.03	0.50	0.02	0.15

Single values are maximum values according to EN ISO 636

### MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)	Test Temperature
550	630	22	60	-40°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

### OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - I1	DC-

### PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP15390	1.6	1000	5	PAP 20 Tube
XP15392	2.4	1000	5	PAP 20 Tube
XP15394	3.2	1000	5	PAP 20 Tube

