

ER 80S-G (Corten)

Low Alloy WIRE/GTAW

Standards

EN/ISO-Standard - 636-A
EN/ISO-Classification - W Z3Ni1

AWS-Standard - A5.28
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.
- 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

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

DC (-)

Mechanical Properties (Typical)

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	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 % ^a	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

^a (includes copper coating)

Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
6011100578	1.60	1000	5	Cardboard Tube
6011100579	2.40	1000	5	Cardboard Tube
6011100580	3.20	1000	5	Cardboard Tube

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