

**NAME OF PRODUCT:** MasterWeld Corten(ER80S-G) **CLASSIFICATION:** SFA-AWS A5.28 ER80S-G  
**NiCu TIG wire** EN ISO 14341-A- G 50 4 C1/M21 Z3Ni1

**TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL**

Rm (N/mm <sup>2</sup> )	Rs (N/mm <sup>2</sup> )	Al% 5d	Kv + 20°C J	Kv - 40 °C J	HARDNESS HB	HARDNESS HRC
630	550	22		60		

The mechanical characteristics are indicative and could change by the heat of the material, shielding gas, welding parameters and other factors.

**CHEMICAL COMPOSITION (average)**

C %	Si %	Mn%	P %	S %	Cu %	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti%
0,080	0,80	1,40	<0,020	<0,020	< 0,40	0,25	0,80	< 0,05	<0,020	<0,030	< 0,15

Cu including copper coating.

**WELDING PROCESS**

Shielding gas	MIG: EN ISO 14175 C1, M20, M21, M33 and similar
Current and Polarity	MIG: DC+
Welding Position	EN ISO 6947: PA, PB, PC, PD, PE, PF, PG

**APPROXIMATE WELDING PARAMETERS OF THE WIRE**

∅ (mm)	0,80	1,00	1,20
<b>A</b>	80 - 160	150 - 250	220 - 320
<b>V</b>	18 - 22	22 - 28	26 - 32

**DIMENSIONS**

MIG (mm)	0,80	0,90	1,00	1,14	1,20	1,40	1,60

Other sizes on request.

Tolerance and technical supplying condition according to EN ISO 544 and AWS

**CERTIFICATE:** EN 10204 - 3.1 (Chemical Analysis) / EN 10204 - 2.2 (Mechanical Characteristics)

**IDENTIFICATION:** External and internal label  
Stamping on each tig rod

**STORAGE:** Refer to the technical instruction for the handling and the storage of consumables

**APPROVALS:** C E Marking according to EN 13479

**BASE MATERIALS**

Standard	Type
	S235JRW, S235J2G3
	Patinax 37, Alcodur50, Korlpin 52,
	S355J2G3Cu, 9CrNiCuP3-2-4
	Corten A - B1
	Itacor
	WTsT52.3, S355K2W

**APPLICATIONS**

Excellent resistance to atmospherical agents thanks to the presence of Cu, Cr, Ni.  
Suitable for bridges, cranes, ground moving machines, boilers, building structures, petrolchemical sector, fans, gas pipes, fume suction, etc.

**SPECIAL FINISHING**