# MIGF75

*Old reference*: MIG CORTEN

## Classification

AWS A5.28 : ER80S-G

ISO 16834-A : G Z Mn3Ni1Cu

## Description & Applications

Copper coated solid wire for GMAW, alloyed with Cu-Ni-Cr, for welding all steels resistant to atmospheric corrosion (industrial, sea, rural).

**Main applications:** Public buildings, department of civil engineering, navy, tanks, water tower, bridges, crash barrier, and electrical pylons.

**Base materials:**

| **Steels with improved resistance to atmospheric corrosion:** | | | |
|---|---|---|---|
| UNS | DIN | EN | Mat. N° |
| | WT St37-2 | S255 JOW | 1.8958 |
| | WT St37-3 | S235 J2W | 1.8961 |
| K 11538; K 11541; K 12032 | WT St52-3 | S355 J2G1W | 1.8963 |
| Trademarks: COR-TEN A,B,C – PATINAX – INDATEN – ACOR | | | |

## Typical Chemical Composition ( % )

| C | Si | Mn | Cr | Ni | Cu | P | S | Fe |
|---|---|---|---|---|---|---|---|---|
| 0.08 | 0.8 | 1.4 | 0.4 | 0.8 | 0.4 | 0.02 | 0.01 | Rem. |

## All Weld Metal Mechanical Properties

| $R_e$ ( MPa ) | $R_m$ ( MPa ) | $A_5$ ( % ) | KV ( J ) |
|---|---|---|---|
| 530 | 620 | 26 | -20°C 90 |

## Welding Current & Instructions

| Welding mode | Wire Ø (mm) | Welding parameters | | Shielding Gas |
|---|---|---|---|---|
| | | Pulsed arc (A) | (V) | |
| MIG<br>= + | 1.0<br>1.2 | 150-170<br>180-250 | 25-28<br>26-28 | EN 439:<br>M21 (Ar/$CO_2$)<br>C1 (100% $CO_2$)<br>12-15 l/min |

Ind.10

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