

# COR-TEN

## Weathering Fine Grain Structural Steel

	TKSE Short name	EN-Short name	Material No.	Material Specification
Heavy plates/hot rolled sheet	COR-TEN A	S355J2WP+N	1.8946	531
Weldable plates	COR-TEN B	S355J2W+N	1.8965	532

### Scope

COR-TEN A applies to plates up to 12.5mm in thickness, COR-TEN B applies to plates up to 50mm in thickness. The values given in the following tables for the mechanical properties are pertinent to the state of delivery condition.

### Definition

Weathering means that due to their chemical compositions COR-TEN A and COR-TEN B steels, when utilised unprotected, exhibits increased resistance to atmospheric corrosion compared to unalloyed steels. This is because it forms a protective layer on its surface under the influence of the weather.

The corrosion retarding effect of the protective layer is produced by the nature of its structure components and the particular distribution and concentration of alloying elements in it. The layer protecting the surface develops and regenerates continuously when subjected to the influence of the weather.

Formation, duration of development and protective effect of the covering layer on weathering steels depend largely upon the corrosive character of the atmosphere. Its influence varies and depends mainly upon the general weather conditions (e.g. continental) macroclimate (e.g. industrial, urban, maritime, or country-side climate) and the orientation of the structure components (e.g. exposed to or shaded from the weather, vertical or horizontal position). The amount of aggressive agents in the air has to be taken into account. In general the covering layer offers protection against atmospheric corrosion in industrial, urban and countryside climate.

When utilising this steel in unprotected condition it is up to the designer to take into account the expected loss of thickness due to corrosion and as far as necessary, compensate for it by increasing the thickness of the material.

In cases of particular air pollution by aggressive agents conventional surface protection is recommended. Coating is absolutely necessary in cases of contact with water for long periods, when permanently exposed to moisture, or if it is to be used in the vicinity of the sea. The susceptibility of paint coats to undercreepage by rust is less in the case of weathering steel than in the case of comparable non-weathering steel.

### Applications

The steel is used for various types of welded, bolted, and riveted constructions e.g. steel frame structures, bridges, tanks and containers, exhaust systems, vehicles and equipment constructions.

Basic guidelines for the use of this steel in unprotected condition are described in EN 10025-5 and DASt rule 007.

The entire application technology is of fundamental importance for the performance of the products made from this steel. It must be taken into account that not only general climatic conditions but also specific unfavourable local climate conditions in the broadest sense as well as details of a construction may affect the corrosion behaviour of unprotected weathering steel. The dependency on these facts makes it understandable that no warranty can be given. It is recommended to control the corrosion progress of unprotected parts out of weathering steel exposed to the influence of weather in reasonable time intervals. A minimum thickness of 5mm is recommended when exposed to the weather in the unprotected condition.



## Machining

The methods, tools and working processes to be applied comply with the conditions for unalloyed structural steel according to EN 10025-2.

## Flame Cutting

COR-TEN is suitable for flame cutting provided proper operating methods are used. At temperatures below 5°C a sufficiently wide zone on either side of the intended cut should be preheated. If flame cut edges are to undergo cold forming, the hardening effect should be prevented by preheating – as in the case of S355J2 or the hardened zones must be worked off e.g. by appropriate grinding.

## Welding

COR-TEN can be welded both manually and mechanically, provided the general rules of welding practices are observed. A prerequisite for obtaining identical mechanical properties in the weld and in the base material is the application of suitable welding consumables and the choice of appropriate welding conditions. To consider are EN 10025-5 – Technical delivery conditions for structural steels with improved atmospheric corrosion resistance; and STAHL-EISEN-Werkstoffblatt 088 - Weldable fine grained structural steels, processing directives, especially for welding.

Recommendations for welding are also given in EN 1011 part 1 and part 2 - Welding, Recommendation for welding of metallic materials-.

Lime basic electrodes, inert-gas welding wire, and wire/power combinations equivalent to the tensile strength of S355 are used as welding consumables.

For unprotected use care must be taken that the welded joint is also weather resistant. This is possible by using welding consumables matching the base material.

If due to design or building specification stress relieving is required, it should be performed in the range of temperature from about 530°C to 580°C (see STAHL-EI SEN-Werkstoffblatt 088).

## Bolting and Riveting

Joining elements such as bolts, rivets and their accessories (nuts and washers) must be so selected that the formation of local electro-chemical cells are avoided. The joining elements should preferably consist of weathering steel.

At these joints capillary action can lead to permanent moisture resulting in increased corrosion. Critical zones should therefore be protected by painting, sealing or other protective means.

In the case of high-strength connections (HV) the conditions for non-weathering structural steels as given in DIN 18800 part 1 apply.

## General Information

Unless otherwise agreed in the order, the delivery will be governed by the stipulations outlined in EN 10021.

The admissible tolerances are based on EN 10051 and EN 10029 unless other terms have been agreed upon.

The plates will be supplied with a maximum flatness tolerance according to EN 10029, table 4L. Smaller flatness tolerances can be agreed upon at the time of ordering.

For surface quality requirements EN 10163 is applicable.

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Full specification and details are available on request.  
The above information is provided for guidance purposes only.  
For specific design requirements please contact our technical sales staff.