

Innershield® NR-233

Flux Cored Wire - Self Shielded / All Position

FCAW

Key Features

- ▶ High deposition rates for out-of-position welding
- ▶ Welder-friendly, easy to use and great bead appearance
- ▶ Minimal gas marking
- ▶ Meets AWS D1.8 seismic lot waiver requirements

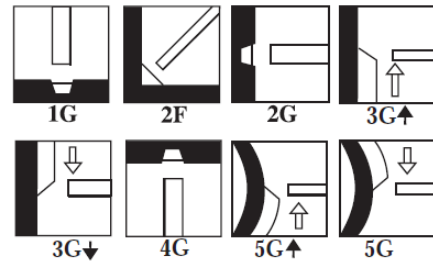
Typical Applications

- ▶ Structural fabrication, including those subject to seismic requirements
- ▶ General plate fabrication
- ▶ Ship and barge fabrication
- ▶ Vertical up and overhead fillets and groove welds

Conformances

AWS A5.20/A5.20M	E71T-8-H16
ASME SFA-A5.20	E71T-8-H16
ABS	E71T-8-H16
AS/NZS ISO 17632-B	T493T8-1NA-H15
AWS D1.8	Meets requirements

Welding Positions



Diameter / Packaging

Diameter mm	Spool - Plastic 11.3kg
1.6	ED030934
1.8	ED031030

Mechanical Properties - As Required per AWS A5.20

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Hardness Rockwell B	Charpy V-Notch J @ -29°C
Requirements - AWS E71T-8	400 min	480-655	22 min	-	27 min
Typical Results - As Welded	435-455	575-595	26-29	87-89	34-54

Deposit Composition

	%C	%Mn	%Si	%S	%P	%Al
Requirements	0.30 max	1.75 max	0.60 max	0.03 max	0.03 max	1.8 max
Typical Results	0.15-0.20	0.61-0.65	0.17-0.21	≤0.03	≤0.01	0.5-0.6