

CLASSIFICATION

AWS A5.20	E71T-8	A-Nr	1
AWS A5.36	E71T8-A2-CS3-H16	F-Nr	6
EN ISO 17632-A	T 42 2 Y N 2 H10	9606 FM	1

GENERAL DESCRIPTION

Self shielded: easiest equipment arrangement
Deposit rate up to 3 kg/h, out of position
Excellent low temperature impact toughness
Ideal for fillet welding and filling
For single and multi-pass welds
Size diam. 1.7mm suitable for contaminated or primed plate

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

CURRENT TYPE

DC -

APPROVALS

ABS	BV	DNV	LR	RINA	TÜV	NKK
3SA,3YSAH15	SA3YMH	IIIMSH15	3S,3YSH15	3YS	+	KSW53NH10

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Al
0.18	0.65	0.27	0.006	0.004	0.55

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
					-20°C	-29°C
Required: AWS A5.20		min. 400	480	22		27
Typical values	AW	490	590	26	65	35

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.7	1.8	2.0
6.12 kg coil 14C	X	X	X
22.68 kg coil 50C	X	X	X

Innershield® NR® 232

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Standard	Type
General structural steels	
EN 10025 part 2	S185, S235, S275, S355
Ship plates	
ASTM A131	Grade A, B, D, AH32 to DH36
Cast steels	
EN 10213-2	GP240R
Pipe material	
EN 10208-1	L210, L240, L290, L360
EN 10208-2	L240, L290, L360, L415
API 5LX	X42, X46, X52, X60
EN 10216-1/ EN 10217-1	P235T1, P235T2, P275T1 P275T2, P355N
Boiler & pressure vessel steels	
EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steels	
EN 10025 part 3	S275, S355, S420
EN 10025 part 4	S275, S355, S420

CALCULATION DATA

Diameter (mm)	Electrical stick-out (mm)	Wire Feed Speed (cm/min)	Current (A)	Arc Voltage (V)	Deposition rate (kg/h)	kg wire/kg weldmetal
1.7	12-25	280	170	19	1.7	1.33
		430	250	21	2.7	1.33
		810	400	26	5.1	1.33
2.0	12-25	200	130	17	1.5	1.22
		430	250	21	2.9	1.22
		730	350	24	5.0	1.22
2.4	12-25	150	130	16	1.3	1.22
		330	250	21	2.8	1.22
		550	350	25	4.6	1.22

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)		Welding positions				
		PA/1G	PB/2F	PC/2G	PF/3Gup	PE/4G
1.7	Wire feed speed (cm/min)	635	495		380	380
	Current (A)	310	275		225	225
	Voltage (V)	23	23		19.5	19.5
1.8	Wire feed speed (cm/min)	635	510	430	390	430
	Current (A)	355	290	255	240	255
	Voltage (V)	11	21	21	20	21
2.0	Wire feed speed (cm/min)	460	380		330	380
	Current (A)	315	285		250	285
	Voltage (V)	23	22		21	22

REMARKS/APPLICATION ADVICE

Designed for the semi-automatic welding of 5mm and thicker steel

Recommended for single and multi-pass welds

Size diam. 1.7mm, is recommended for welds where it is necessary to produce wider passes (weave technique) and for welding plate with contaminations such as oil, rust, paint or primer

Size diam. 1.8mm is recommended to obtain the fastest travel speed on single pass fillet weld

Size diam. 2.0mm is recommended for overhead position