

Innershield® NR®152

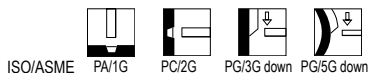
CLASSIFICATION

AWS A5.20/A5.20M : E71T-14
 EN ISO 17632-A : T 42 Z Z N 5

GENERAL DESCRIPTION

Self-shielded : easiest equipment arrangement
Welding galvanized steel
Single pass automatic and semi-automatic
Recommended for sheets from 1.2 to 5.0 mm

WELDING POSITIONS



CURRENT TYPE

DC -

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

C	Mn	Si	P	S	Al	Ti	N
0.30	0.99	0.24	0.013	0.007	1.63	0.003	0.051

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)
Required: AWS A5.20	not required	480	not required	not required
Typical values AW		525*		

* Flat tensile test specimen

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6
Unit : 22.68 kg coil 50C	X

Innershield® NR®152: rev. EN 22

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MATERIALS TO BE WELDED

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

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
1.6	13	75	90	13	0.55	1.11
		125	150	15	0.9	1.11
		280	250	19	2.0	1.11

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)		Welding positions		
		PA/1G PB/2F	PC/2G	PG/3G down
1.2	Wire feed speed (cm/min)	180	150	200
	Current (A)	205	170	220
	Voltage (V)	16.5	18.5	19.5

REMARKS/APPLICATION ADVICE

Spot welds on 0.75mm to 1.5mm thick material

These procedures include automatic processes where excellent striking is required

Galvanized or zinc coated steel may be welded with Innershield NR-152 at travel speeds of 75 to 100 cm/min. The joint design must permit the zinc oxide vapor to diffuse through the molten puddle or to the atmosphere