

INNERSHIELD® NR®-232

Mild Steel, All Position ■ AWS E71T-8, E71T8-A2-CS3-H16

KEY FEATURES

- High deposition rates for out-of-position welding
- Penetrating arc
- Fast freezing, easy to remove slag system
- Meets AWS D1.8 seismic lot waiver requirements

WELDING POSITIONS

All

TYPICAL APPLICATIONS

- Structural fabrication, including those subject to seismic requirements
- General plate fabrication
- Hull plate and stiffener welding on ships and barges
- Machinery parts, tanks, hoppers, racks and scaffolding

CONFORMANCES

AWS A5.20/A5.20M:	E71T-8-H16
AWS A5.36:	E71T8-A2-CS3-H16
ASME SFA-A5.20:	E71T-8-H16
ABS:	3YSA
Lloyd's Register:	3YS H15
DNV Grade:	III YMS H15
GL:	3YH10S
BV Grade:	SA3YMH
CWB/CSA W48-06:	E491T-8 H16
DB:	EN 758 T42 3 Y N 2
TUV:	EN 758 T42 3 Y N 2
MIL-E-24403/1:*	MIL-71T-8AS
FEMA 353	
AWS D1.8	
JIS Z 3313	T49T38-1NA-H15

**Military Grade Classification of MIL-71T-8AS for 0.068 in (1.7 mm) and 0.072 in (1.8 mm) diameters only.*

DIAMETERS / PACKAGING

Diameter in (mm)	13.5 lb (6.1 kg) Coil 54 lb (24.5 kg) Master Carton	13.5 lb (6.1 kg) Coil 54 lb (24.5 kg) Hermetically Sealed Pail	25 lb (11.3 kg) Steel Spool
0.068 (1.7)	ED012518	ED030232	ED030643
0.072 (1.8)	ED012522		ED030644
5/64 (2.0)	ED012525		ED030647
Diameter in (mm)	25 lb (11.3 kg) Plastic Spool (Vacuum Sealed Foil Bag)		50 lb (22.7 kg) Coil
0.068 (1.7)	ED030949		ED012519
0.072 (1.8)			ED012523
5/64 (2.0)			ED012526

MECHANICAL PROPERTIES⁽¹⁾

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Hardness Rockwell B	Charpy V-Notch / J ft•lbf) @ -29°C (-20°F)
Requirements - AWS E71T-8	400 (58) min	480-655 (70-95)	22 min	-	27 (20) min
Typical Results⁽³⁾ - As-Welded	460-520 (66-75)	575-615 (83-89)	25-31	87-90	47-75 (35-55)

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer

NOTE: FEMA 353 and AWS D1.8 structural steel seismic supplement test data can be found on this product at www.lincolnelectric.com.

DEPOSIT COMPOSITION⁽¹⁾

	%C	%Mn	%Si	%S	%P	%Al
Requirements - AWS E71T-8	0.30 max	1.75 max	0.60 max	0.03 max	0.03 max	1.8 max
Typical Results⁽³⁾	0.16-0.18	0.61-0.72	0.26-0.33	≤0.01	≤0.01	0.5-0.8

TYPICAL OPERATING PROCEDURES

Diameter, Polarity	CTWD ⁽²⁾ mm (in)	Wire Feed Speed m/min (in/min)	Voltage ⁽²⁾ (volts)	Approx. Current (amps)	Melt-Off Rate kg/hr (lb/hr)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)
0.068 in (1.7 mm), DC-	19-32 (3/4-1 1/4)	2.8 (110)	18-19	195	2.3 (5.0)	1.8 (3.9)	78
		3.3 (130)	19-21	225	2.8 (6.2)	2.0 (4.6)	74
		3.8 (150)	19-21	250	3.2 (7.1)	2.4 (5.3)	75
		4.3 (170)	20-22	270	3.5 (7.8)	2.8 (6.1)	78
		5.0 (195)	23-24	300	4.3 (9.4)	3.2 (7.0)	74
		6.4 (250)	23-24	350	5.4 (11.8)	4.0 (9.0)	76
0.072 in (1.8 mm), DC-	19-32 (3/4-1 1/4)	7.4 (320)	25-27	400	6.9 (15.2)	5.2 (11.4)	75
		2.0 (80)	16-18	130	1.8 (4.0)	1.5 (3.3)	83
		3.5 (140)	18-21	225	3.1 (6.8)	2.5 (5.5)	81
		3.9 (155)	19-22	240	3.3 (7.2)	2.7 (6.0)	83
		4.3 (170)	20-23	255	3.6 (8.0)	2.9 (6.5)	81
		6.4 (250)	22-24	315	5.3 (11.7)	4.3 (9.6)	82
5/64 in (2.0 mm), DC-	19-32 (3/4-1 1/4)	7.4 (290)	23-25	350	6.2 (13.6)	5.0 (11.0)	81
		1.5 (60)	16-17	145	1.7 (3.7)	1.2 (2.7)	73
		2.9 (115)	19-20	260	3.2 (7.0)	2.5 (5.5)	78
		3.0 (120)	19-20	270	3.3 (7.3)	2.6 (5.7)	78
		3.3 (130)	20-21	285	3.5 (7.8)	2.8 (6.2)	79
		4.6 (180)	22-23	365	5.0 (10.9)	3.9 (8.7)	80

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer
 NOTE: FEMA 353 and AWS D1.8 structural steel seismic supplement test data can be found on this product at www.lincolnelectric.com.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

