

Innershield® NR®-152

Self-shielded cored wire

Classification

AWS A5.20-95 : E71T-14

General description

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

Welding positions



ISO/ASME PA/1G PC/2G PG/3G down PG/5G down

Current type

DC -

Approvals

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, all weld metal

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation %	Impact ISO-V(J)
Required:	AWS A5.20-95	not required	480	not required	not required
Typical values	AW		525*		

* Flat tensile test specimen

Packaging and available sizes

Unit type	Net weight/unit (kg)	Diameter (mm)
Coils 50C	22.68	X

Innershield® NR®-152: rev. EN 15

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Suggestions for use

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

Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S185, S235, S275, S355
Ship plates	ASTM A131	Grade A, B, D, AH32 t/m 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/ EN 10217-1	P235T1, P235T2, P275T1 P275T2, P355N
	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Boiler & pressure vessel steel	EN 10113-2	S275, S355
Fine grained steel	EN 10113-3	S275, S355

Calculation data at normal setting

Diameter (mm)	Electrical Stick-out (mm)	Wire feed speed		Current (approx. A)	Arc Voltage (V)	Deposition Rate (kg/h)	kg Wire/ kg Weldmetal
		inch/min	cm/min				
1.6	13	30	75	90	13	0.55	1.11
		50	125	150	15	0.9	1.11
		110	280	250	19	2.0	1.11

Welding parameters, optimum fill passes

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