

# Innershield® NR®-207-H

## Self-shielded cored wire

### Classification

AWS A5.29-98 : E71T8-K6

### General description

Self shielded: easiest equipment arrangement  
Vertical down semi-automatic pipe welding  
High quality construction welding in all positions  
Good impact and CTOD toughness  
Low hydrogen weld metal H

### Welding positions



ISO/ASME PA/1G PB/2F PC/2G PG/3G down PE/4G PG/5G down

### Current type

DC -

### Approvals

### Chemical composition (w%), typical, all weld metal

C	Mn	Si	P	S	Ni	Al
0.07	0.9	0.20	0.005	0.003	0.85	1.0

### Mechanical properties, all weld metal

	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation %	Impact ISO-V(J) -29°C
Required:	AWS A5.29-98	min. 400	480-620	20	27
Typical values	AW	420	535	25	110

### Packaging and available sizes

Unit type	Net weight/unit (kg)	Diameter (mm)
Coils 14C	6.35	X

Innershield® NR®-207-H: rev. EN 15

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## Suggestions for use

Where low hydrogen weld metal is required

High productivity welding

Where arctic mechanical properties are required in general construction welding

Semi-automatic pipe welding

## 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 to DH36.
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
	EN 10113-2 EN 10113-3	S275, S355 S275, S355
Fine grained steel		

## Calculation data at normal setting

Diameter (mm)	Electrical Stick-out (mm)	Wire feed speed inch/min cm/min	Current (approx. A)	Arc Voltage (V)	Deposition Rate (kg/h)	kg Wire/ kg Weldmetal
1.7	19	90	205	17.5	1.5	-
		105	220	18.5	1.8	-
		115	245	19.5	2.0	-