

Innershield® NR®-208-H

Self-shielded cored wire

Classification

AWS A5.29-98 : E91T8-G

General description

Self shielded: easiest equipment arrangement
Semi-automatic fill and cap pass welding of X-80 pipe steel in vertical down position
Excellent low temperature toughness
Low hydrogen (max. 8 ml/100 gr.)

Welding positions



ISO/ASME PG/5G down

Current type

DC -

Approvals

TÜV

+

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

C	Mn	Si	P	S	Al	Ni
0.05	1.65	0.25	0.007	<0.003	0.85	0.8

Mechanical properties, all weld metal

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation %	Impact ISO-V(J) -30°C
Required:	AWS A5.29-98	min. 540	620-760	17	
Typical values	AW (1G)	585	650	26	115

Packaging and available sizes

Unit type	Net weight/unit (kg)	Diameter (mm)	
		1.7	2.0
Coils 14C	6.35	X	X

Innershield® NR®-208-H: rev. EN 15

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Suggestions for use

Preheat and interpass temperature depending on steel quality

For root pass welding of X-60 to X-80 the Innershield NR-204-H electrode is recommended

Materials to be welded

Steel	Code	Type
Pipe material	API5LX	X-60 tot X-80
	EN 10208-2	L 415, L445, L480, L550

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	60	150	145	15.5	1.0	-
		80	205	180	17.5	1.3	-
		105	270	215	18.5	1.8	-
		145	370	255	20.5	2.4	-