

Innershield® NR-211-MP

Key Features

- Versatile welding capability on a variety of base materials
- High operator appeal and good bead appearance
- Easy slag removal
- Fast freezing characteristics accommodate poor fit-up

Typical Applications

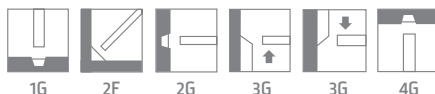
- Sheet or thin gauge metal
- Galvanized sheet metal
- General fabrication
- Small diameters ideally suited to DIY welders

Conformances

AWS A5.20/A5.20M: E71T-11

AS/NZS ISO 17632-B: T49 Z T11 1NA-H15

Welding Positions



Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts*	Current amps	CTWD mm
0.9	ED016354	Spool Plastic 4.5kg	50-270	14-21	30-155	13-16
1.1	ED016363	Spool Plastic 4.5kg	70-130	15-19	120-170	16-19
1.1	ED030638	Spool Steel 11.3kg				
1.7	ED012506	Coil 6.4kg	40-175	15-24	125-300	19-32
1.7	ED030641	Spool Steel 11.3kg				
2.0	ED012508	Coil 6.4kg	50-160	16-23	180-325	19-32
2.0	ED030645	Spool Steel 11.3kg				

*Polarity DC-

Maximum Plate Thickness: 0.9/1.2mm ≤ 8mm, 1.7/2.0mm ≤ 13mm

Mechanical Properties - As required per AWS A5.20

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Hardness HRB
Requirements - AWS E71T-11	390 min	490-670	20 min	-
Typical Results - As Welded	435-475	605-645	22-25	89-92

Deposit Composition

	%C	%Mn	%Si	%S	%P	%AL
AWS Requirements	0.30 max	1.75 max	0.60 max	0.03 max	0.03 max	1.8 max
Typical Results	0.23-0.26	0.57-0.66	0.17-0.26	≤0.01	≤0.01	1.3-1.6