

Innershield® NR® 555

CLASSIFICATION

AWS A5.36	E81T8-A5-K8-H8	A-Nr	10
EN ISO 17632-A	T 46 5 ZY N1 H10	F-Nr	6
EN ISO 17632-B	T 55 5 T8-1 N A-G-H10	9606 FM	1

GENERAL DESCRIPTION

Welder friendly operability and flat bead face in out-of-position fillets and groove welds
 Meets AWS D1.8 seismic lot waiver requirements
 Impact properties at -40/50°C
 Available in vacuum packaging

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PG/3Gd



PE/4G

CURRENT TYPE

DC -

APPROVALS

AWS D1.8 **CE**

+

+

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Al	Ni	HDM
0.05	1.84	0.17	0.011	0.001	0.84	1.12	5 ml/100g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)
					-46°C
Required: AWS A5.36		min. 400	min. 480	min. 22	
EN ISO 17632-A		min. 460	530-680	min. 20	min. 47
Typical values	AW	550	630	25	100

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6	2.0
11.3 kg plastic spool	X	X

Innershield® NR® 555: rev. C-EN01-14/1/17

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Standard	Type
General structural steels EN10027-1	S235 - S460; J2, K2, N and NL, M and ML
Ship plates ASTM, ABS, DNV	Grade A, D, EH32 to 40; NV A,D,E 32-40; NV A,D,E 420-460
Pipe material ISO 3183 API 5LX	L245-L415N, L245-L450Q, L245M - L450M X42, X46, X52, X60, X65
Boiler & pressure vessel steels EN 10028-2 EN 10028-3	P235-355GH P235-460, N, NH, NL
Fine grained steels EN 10025-2, -3, -4 EN 10025 EN 10025-6	S235, S275; S355, S420, S420, S460, S460, S460, S460 N, NL, M, ML S355G, S420G grades S460Q, QL

WELDING PARAMETERS, TYPICAL OPERATING PROCEDURES

Diameter (mm)	CTWD (mm)	WFS (m/min)	Voltage (V)	Current (A)	Deposition rate (kg/h)
1.6	22	2.8	19	185	1.5
2.0	22	2.8	19	245	2.5

FCAW