

Innershield® NR-311

Key Features

- High deposition rates and fast travel speeds
- Easy slag removal
- Optimal toe wash-in
- Deep penetration
- High resistance to cracking

Typical Applications

- Recommended for fillet, lap and butt welds on 3.2 mm and thicker steel, including some low alloy steels
- General fabrication
- Assembly welding
- Welds on lightly rusted or primed plate

Conformances

AWS A5.20/A5.20M: E70T-7

Welding Positions



Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts*	Current amps	CTWD mm
2.0	ED014464	Coil 6.4kg - Carton 25.4kg	100-240	21-29	170-300	30-35
2.4	ED012629	Coil 22.7kg	75-200	20-29	200-390	35-40

*Polarity DC-

Mechanical Properties - As required per AWS A5.20

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Hardness HRB
Requirements - AWS E70T-7	390 min	490-670	22 min	-
Typical Results - As Welded	420-475	600-645	23-26	88-92

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	0.25-0.29	0.44-0.51	0.09-0.12	≤0.01	≤0.01	1.4-1.7