

# Innershield® NR®-152

## TOP FEATURES

- Designed for high speed welding of specially coated steels.
- Soft, consistent arc.
- Porosity resistant.
- Excellent overlapping capabilities.
- Ideal for robotic applications.

## TYPICAL APPLICATIONS

- Single pass welding on thicknesses from 0.8 mm - 4.8 mm (0.030 - 3/16 in)
- Spot or short intermittent welds
- Continuous welding on galvanized or zinc coated carbon steel
- Automotive
- Transportation

## CLASSIFICATION

AWS A5.36 E71T-14

## CURRENT TYPE

DC -

## WELDING POSITIONS

All positions

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Al	Ti	N
0.30	0.99	0.24	0.013	0.007	1.63	0.003	0.051

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)
Required: AWS A5.20		not specified	480	not specified	not specified
Typical values	AW		525**		

\* AW = As welded

\*\* Flat tensile test specimen

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.1	SPOOL	11.3	EDS01702
	DRUM	227.0	ED028123
1.6	DRUM	227.0	ED029066

### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.