Innershield® NR®-203 Ni1

TOP FEATURES

- Designed to produce a nickel bearing weld deposit
- Capable of producing weld deposits with impact toughness exceeding 27 J at -29°C
- Color match on weathering steels
- Handles poor fit-up
- Root bead capability

TYPICAL APPLICATIONS

- Roundabout groove welds on heavy wall tubular construction
- Offshore
- Bridges and other structural components made from weathering steels
- Structural fabrication
- NACE applications

CLASSIFICATION

A5.29/A5.36	E71T8-Ni1-H16
	E71T8-A2-Ni1-H16
EN ISO 17632-A	T 42 4 1Ni Y N 1 H10

CURRENT TYPE

DC -

WELDING POSITIONS

All

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

C	Mn	Si	P	S	Ni	Al
0.08	1.1	0.27	0.008	0.003	0.9	0.85

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -29°C
Required: AWS A5.29		min. 400	480-620	20	27
Typical values	AW	465	540	26	115

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
2.0	COIL	6.4	ED012385
	COIL	22.7	ED012386

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 for any updated information.