

Innershield® NR-203MP

Key Features

- Designed to handle poor fit-up on heavy wall tubes and gaps up to 9.5 mm (3/8 in) with 6.4 mm (1/4 in) offset
- Fast freezing slag with excellent wash-in
- Root bead capability without back-up bars

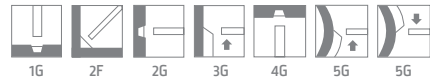
Typical Applications

- General plate fabrication, including bridge fabrication, hull plate and stiffener welding on ships and barges
- Storage tanks
- Structural welding
- Offshore welding in TKY joints

Conformances

AWS A5.20/A5.20M:	E71T-8-JH8
ABS:	3YSA H15
Lloyd's Register:	3YS H15
DNV-GL:	III YMS H10
BV:	SA3YMH
CSA W48:	E491T8-A4-CS3-H8 [E491T-8-JH8]

Welding Positions



Diameter / Packaging

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts*	Current amps	CTWD mm
1.7	ED030640	Steel Spool 11.3kg	70-150	16-24	145-265	25

*DC-

Mechanical Properties - As required per AWS A5.20

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -40°C
Requirements - AWS E71T-8-J	390 min	490-670 min	22 min	27 min
Typical Results - As Welded	400	500-570	26	35-398

Deposit Composition

	%C	%Mn	%Si	%S	%P	%AL	Diffusible Hydrogen ml / 100g
AWS Requirements	0.30 max	1.75 max	0.60 max	0.03 max	0.03 max	1.8 max	8 max
Typical Results	0.05-0.07	1.25-1.56	0.20-0.28	≤0.004	≤0.012	0.7-1.1	5.3