

Innershield® NR®-311

TOP 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 (1/8 in) and thicker steel, including some low alloy steels
- Horizontal butt welds, such as column-to-column structural connections
- General fabrication
- Assembly welding

CLASSIFICATION

A5.20/A5.36 E70T-7

CURRENT TYPE

DC -

WELDING POSITIONS

Flat/Horizontal

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

C	Mn	Si	P	S	Al
0.27	0.4	0.08	0.007	0.005	1.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)
Required: AWS A5.20		min. 400	480	22
Typical values	AW	430	590	25

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
2.0	SPOOL	11.3	ED030649
2.4	COIL	22.7	ED012629

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.