

Innershield® NR® 208-H

CLASSIFICATION

AWS A5.29	E91T8-G	A-Nr	1
		F-Nr	6
		9606 FM	2

GENERAL DESCRIPTION

Self shielded: easiest equipment arrangement
 Semi-automatic fill and cap pass welding of X-80 pipe steel in vertical down position
 Excellent low temperature toughness
 Low hydrogen content (HDM < 8 ml/100g)

WELDING POSITIONS (ISO/ASME)



P/J5Gd

CURRENT TYPE

DC -

APPROVALS

TÜV

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

C	Mn	Si	P	S	Al	Ni
0.05	1.65	0.25	0.007	<0.003	0.85	0.8

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)
					-30°C
Required: AWS A5.29		min. 540	620-760	17	
Typical values	AW (1G)	585	650	26	115

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.7	2.0
6.35 kg coil 14C	X	X

Innershield® NR® 208-H.rev. C-EN22-01/02/16

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Standard	Type
Pipe material	
API 5LX	X60, X70
EN 10208-2	L 415, L445, L480, L550

CALCULATION DATA

Diameter (mm)	Electrical stick- out (mm)	Wire Feed Speed (cm/min)	Current (A)	Arc Voltage (V)	Deposition rate (kg/h)	kg wire/ kg weldmetal
1.7	19	150	145	15.5	1.0	-
		205	180	17.5	1.3	-
		270	215	18.5	1.8	-
		370	255	20.5	2.4	-

REMARKS/APPLICATION ADVICE

Preheat and interpass temperature depending on steel quality
For root pass welding of X-60 to X-80 the Innershield NR-204-H electrode is recommended