

# Innershield® NR-212

## Key Features

- Suitable for a wide range of mild steels
- Fast freeze characteristics accommodate poor fit-up
- Smooth arc performance and ease of use

## Typical Applications

- Single or multiple pass welding with a maximum plate thickness of 20mm
- General fabrication
- Truck bodies, tanks, hoppers, racks and scaffolding
- Welding on galvanized steel or zinc coated carbon steel

## Conformances

AWS A5.29/A5.29M: E71TG-G

## Welding Positions



## Diameter / Packaging

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts*	Current amps	CTWD mm
1.1	ED030639	Steel Spool 11.3kg	55-160	14-20	75-170	15-20
1.7	ED030642	Steel Spool 11.3kg	60-175	16-23	145-275	20-25
2.0	ED030646	Steel Spool 11.3kg	60-150	16-23	200-325	20-25

\*Polarity DC-

## Mechanical Properties - As required per AWS A5.20

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Hardness Rockwell B
Requirements - AWS E71TG-G	390 min	490-670	20 min	-
Typical Results - As Welded	440-505	575-605	24-28	89-92

## Wire Composition

	%C	%Mn	%Si	%S	%P	%Ni	%Al
AWS Requirements	NS	0.50 min	1.00 max	0.030 max	0.030 max	0.50 min	1.8 max
Typical Results	0.06-0.11	0.84-1.55	0.20-0.33	≤0.003	0.007	1.02 -1.15	1.3-1.6