

Innershield® NR-555

Key Features

- Higher strength self shielded wire for welding in structural applications requiring excellent toughness
- Welder-friendly, flat bead face in out of position fillets and butt welds
- Meets AWS D1.8 seismic lot waiver requirements
- Foil bag shields against moisture, prevents rust and prolongs storage life, AWS H8 rated wire

Typical Applications

- Structural fabrication, including those subject to seismic requirements
- General plate fabrication
- Bridges
- Vertical up and overhead fillets and groove welds
- Weathering steels

Conformances

AWS A5.29: E81T8-G
AS/NZS ISO 17632-A: T46 5 ZY N1 H10
AWS D1.8: Meets requirements

Welding Positions



Diameter / Packaging

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts*	Current amps	CTWD mm
1.6	ED035565	Spool Plastic VFB 11.3kg	75-120	16-20	145-200	20-25

*Polarity DC-

Mechanical Properties - As required per AWS A5.29

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -46°C
E81T8-G	470 min	550-690	19 min	-
Typical Results - As Welded	550	630	25	100

Deposit Composition

	%C	%Mn	%Si	%S	%P	%Ni
Requirements -AWS 5.29: E81T8-G	0.15 max	1.00-2.00	0.40 max	0.030 max	0.030 max	0.50-1.50
Typical Results - As Welded	0.05	1.84	0.17	0.001	0.011	1.12
	%Cr	%Mo	%V	%Al	Diffusible Hydrogen (mL/100g weld deposit)	
Requirements -AWS 5.29: E81T8-G	0.20 Max	0.20 Max	0.05 Max	1.80 Max	-	
Typical Results - As Welded	0.05	0.01	0.00	0.84	5	