

Innershield® NR®-232

TOP FEATURES

- High deposition rates for out-of-position welding
- Penetrating arc
- Fast freezing, easy to remove slag system
- Meets AWS D1.8 seismic lot waiver requirements
- Notes: AWS D1.8 structural steel seismic supplement test data can be found at the Lincoln Electric Certificate Center.

TYPICAL APPLICATIONS

- Structural fabrication, including those subject to seismic requirements
- General plate fabrication
- Hull plate and stiffener welding on ships and barges
- Machinery parts, tanks, hoppers, racks and scaffolding

CLASSIFICATION

A5.20/A5.36	E71T-8-H16
	E71T8-A2-CS3-H16
EN ISO 17632-A	T 42 2 Y N 2 H10

CURRENT TYPE

DC -

WELDING POSITIONS

All

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

C	Mn	Si	P	S	Al
0.18	0.65	0.27	0.006	0.004	0.55

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-20°C	-29°C
Required: AWS A5.20		min. 400	480	22		27
Typical values	AW	490	590	26	65	47-75

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.7	COIL	6.1	ED012518
	SPOOL	11.3	ED030643
	COIL	22.7	ED012519
1.8	COIL	6.1	ED012522, ED030232
	SPOOL	11.3	ED030644, ED030949
	COIL	22.7	ED012523
2.0	COIL	6.1	ED012525
	SPOOL	11.3	ED030647
	COIL	22.7	ED012526

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.