

Innershield® NR-152

Key Features

- Designed for high speed welding of specially coated steels
- Soft, consistent arc
- Resistant to porosity
- Excellent overlapping capabilities
- Ideal for robotic applications

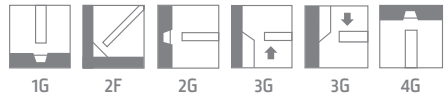
Typical Applications

- Single pass welding on plate thickness up to 5mm (not recommended for welding multiple passes)
- Continuous welding on galvanized or zinc coated carbon steel
- Spot or short intermittent welds
- Automotive and Transportation

Conformances

AWS A5.20/A5.20M: E71T-14

Welding Positions



Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts*	Current amps	CTWD mm
1.7	ED012186	Coil 22.7kg	30-110	13-21	70-240	15-20

*Polarity DC-

Mechanical Properties - As required per AWS A5.20

	Transverse Tensile Strength MPa	Hardness Rockwell B
Requirements - AWS E71T-14	490 min	-
Typical Results	480-550	93

Deposit Composition

	%C	%Mn	%Si	%S	%P	%AL
AWS Requirements	Not Specified					
Typical Results	0.25-0.30	0.83-1.04	0.20-0.23	0.006-0.01	0.005-0.02	1.08-1.38