

# Innershield® NR-233

## Key Features

- High deposition rates for out-of-position welding
- Welder-friendly, easy to use and great bead appearance
- Minimal gas marking
- Meets AWS D1.8 seismic lot waiver requirements

## Typical Applications

- Structural fabrication, including those subject to seismic requirements
- General plate fabrication
- Ship and barge fabrication
- Vertical up and overhead fillets and groove welds

## Conformances

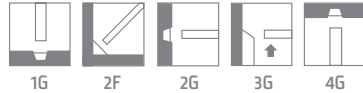
**AWS A5.20/A5.20M:** E71T-8-H8

**AS/NZS ISO 17632-B:** T49 3 T8-1 NA UH10

**AWS D1.8:** Meets lot requirements

**ABS:** 3YSA

## Welding Positions



## Diameter / Packaging

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts*	Current amps	CTWD mm
1.6	ED030933	Plastic Spool 5.7kg (22.7kg Carton)	150-350	17-27	220-315	19-25
1.6	ED031576	Plastic Spool VFB 11.3kg				
1.8	ED031030	Plastic Spool 11.3kg	100-300	17-24	180-355	19-25

\*Polarity DC-

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

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -30°C
Requirements - AWS E71T-8	390 min	490-670 min	22 min	27 min
Typical Results - As Welded	430	560-610	25	41-75

## Deposit Composition

	%C	%Mn	%Si	%S	%P	%AL	Diffusible Hydrogen (mL/100g weld deposit)
AWS Requirements	0.30 max	1.75 max	0.60 max	0.03 max	0.03 max	1.8 max	8 max
Typical Results	0.16-0.20	0.58-0.69	0.18-0.24	0.011	0.010	0.6-0.8	5.5