

Innershield® NR-232

Key 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

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

Conformances

AWS A5.20/A5.20M: E71T-8-H16
AS/NZS ISO 17632-B: T55 3 T8-1 NO A H10
Lloyds Register: 3YS H15
ABS: 3YSA
DNV-GL: III YMS H15
AWS D1.8: Meets lot requirements
BV: SA3YMH

Welding Positions



Diameter / Packaging

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts*	Current amps	CTWD mm
1.7	ED012518	Coil 6.1kg Carton 24.5kg	110-320	18-27	200-400	19-32
	ED030643	Steel Spool 11.3kg				
	ED012519	Coil 22.7kg				
2.0	ED012525	Coil 6.1kg Carton 24.5kg	60-180	16-23	150-365	19-32
	ED030647	Steel Spool 11.3kg				
	ED012526	Coil 22.7kg				

*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	22 min	27 min
Typical Results - As Welded	410	560-630	24	38-84

Deposit Composition

	%C	%Mn	%Si	%S	%P	%AL	Diffusible Hydrogen ml/100g
AWS Requirements	0.30 max	1.75 max	0.60 max	0.03 max	0.03 max	1.8 max	16 max
Typical Results	0.13-0.21	0.61-0.72	0.24-0.34	≤0.010	≤0.013	0.6-0.8	8.5