



Product Data Sheet

T 'Tubular cored electrode arc welding'

Coreshield 15

Signed by Neil Farrow	Approved by Neil Farrow/Christos Skodras	Reg no EN003888	Cancelling PS000136	Reg date 2007-04-19	Page 1 (1)
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REASON FOR ISSUE

A new specification

GENERAL

An all positional self-shielded cored wire. Designed for the welding of thin gauge steel.

Shielding Gas: None

Alloy Type: C Mn

Polarity: DC-

Fill Type: Self-shielded

CLASSIFICATIONS Weld Metal

SFA/AWS A5.20 E71T-GS

APPROVALS

Not applicable

CHEMICAL COMPOSITION

	All Weld Metal (%)	
	Min	Max
C	0.15	0.35
Si	0.10	0.50
Mn	0.50	1.20
P		0.030
S		0.030
Al	1.60	2.90

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	Min
Rm (MPa)		497

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U	
	Min	Max	Nom	Nom	Min	Max	Min	Max	Min	Max
$\emptyset$ 0.8	40	100		78			3.0	7.0	14	16

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)