

Coreshield 15

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

Classifications	SFA/AWS A5.20 : E71T-GS
------------------------	-------------------------

Welding Current	DC-
Alloy Type	C Mn

Typical Tensile Properties

Condition	Tensile Strength
As Welded	614 MPa

Typical Weld Metal Analysis %

C	Mn	Si	Al
0.23	0.70	0.40	1.98

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	TTW Dist.	Deposition Rate
0.9 mm	80-200 A	15-17 V	2.06-9.95 m/min	9.5 mm	0.4-2.0 kg/h
1.2 mm	95-225 A	15-18 V	1.37-3.56 m/min	12.5 mm	0.4-1.2 kg/h
1.6 mm	160-275 A	17-19 V	1.42-3.35 m/min	16.0 mm	1.0-2.4 kg/h

Recommended Welding Parameters

	Current	Voltage
--	---------	---------