



Product Data Sheet

Coreshield 8

T 'Tubular cored electrode arc welding'

Prepared by Daniel Amahatsion	Qualified by Tero Borg	Approved by Neil Farrow	Reg no EN006992	Cancelling EN006668	Reg date 2016-01-21	Page 1 (2)
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REASON FOR ISSUE

Typical mechanical values added

GENERAL

An all positional self-shielded cored wire ideal for welding outdoor structural steelwork.

Shielding Gas: None

Alloy Type: C Mn

Polarity: DC-

CLASSIFICATIONS Weld Metal

SFA/AWS A5.20 E71T-8
EN ISO 17632-A T 42 2 Y N 2

APPROVALS

ABS 3YSA H10
BV SA3YM H10
CE EN 13479
CWB E491T-8-H16
DB 42.039.35
DNV III YMS H10
GL 3YS
LR 3YS H10
NAKS/HAKC 1.6MM
VdTÜV 10019

CHEMICAL COMPOSITION

All Weld Metal (%)

	No shielding gas	
	Min	Max
C	0.14	0.26
Si	0.07	0.20
Mn	0.3	0.8
P		0.02
S		0.02
Cr		0.1
Ni		0.25
Mo		0.03
V		0.02
Nb		0.01
Cu		0.10
Al	0.35	0.85

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	No shielding gas		
	As welded		
	Min	Max	Typ
Rp0.2 (MPa)	400		457
Rm (MPa)	490	600	552
A4 (%)	22		26
Charpy V at -20°C (J)	47		75
Charpy V at -29°C (J)	41		63



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ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed			U
	Min	Max	Nom	Nom	Min	Max	Min	Max	Min	Max
\emptyset 1.6	155	240		78	1.9	3.7	3.8	7.6	21	25

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)