



FLUX-CORED SELF-SHIELDED (FCAW-S) WIRE

Innershield® NR®-233

Mild Steel, All Position • AWS E71T-8

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: 2005 E71T-8-H16
ASME SFA-A5.20: E71T-8-H16
ABS: E71T-8-H16
EN ISO 17632-B: T493T8-1NA-H15
FEMA 353
AWS D1.8

Welding Positions

All

Notes

- ▶ Innershield® K126 Gun Assembly requires one of the following gun tube assemblies for better wire feeding - KP2454-1 (62°, 7.5 in), KP2455-1 (45°, 6 in), KP2456-1 (30°, 12 in)

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(AWS E71T-8)

DIAMETERS / PACKAGING

Diameter in (mm)	12.5 lb (5.7 kg) Plastic Spool 50 lb (22.7 kg) Master Carton	25 lb (11.3 kg) Plastic Spool	25 lb (11.3 kg) Plastic Spool (Vacuum Sealed Foil Bag)
1/16 (1.6)	ED030933	ED030934	ED031576
0.072 (1.8)		ED031030	
5/64 (2.0)		ED033039	ED033024

MECHANICAL PROPERTIES⁽¹⁾ – As Required per AWS A5.20/A5.20M: 2005

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Hardness Rockwell B	Charpy V-Notch J (ft•lbf) @ -29°C (-20°F)
Requirements - AWS E71T-8	400 (58) min.	480-655 (70-95)	22 min.	–	27 (20) min.
Typical Results ⁽³⁾ - As-Welded	435-455 (63-66)	575-595 (83-86)	26-29	87-89	34-54 (25-40)

DEPOSIT COMPOSITION⁽¹⁾ – As Required per AWS A5.20/A5.20M: 2005

	%C	%Mn	%Si	%S	%P	%Al
Requirements - AWS E71T-8	0.30 max.	1.75 max.	0.60 max.	0.03 max.	0.03 max.	1.8 max.
Typical Results ⁽³⁾	0.15-0.20	0.61-0.65	0.17-0.21	≤0.03	≤0.01	0.5-0.6

TYPICAL OPERATING PROCEDURES

Diameter, Polarity	CTWD ⁽⁴⁾ mm (in)	Wire Feed Speed m/min (in/min)	Voltage (volts)	Approx. Current (amps)	Melt-Off Rate kg/hr (lb/hr)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)
1/16 in (1.6 mm), DC-	25 (1)	3.8 (150)	17-19	220	2.4 (5.3)	1.9 (4.2)	80
		5.1 (200)	19-21	245	3.2 (7.1)	2.5 (5.4)	76
		6.4 (250)	21-23	270	4.0 (8.9)	3.0 (6.6)	74
		7.6 (300)	23-25	295	4.7 (10.4)	3.5 (7.7)	75
		8.9 (350)	25-27	315	5.6 (12.3)	4.3 (9.4)	77
0.072 in (1.8 mm), DC-	19-25 (3/4-1) ⁽⁴⁾	2.5 (100)	17-18	184	2.0 (4.5)	1.6 (3.6)	80
		3.8 (150)	18-19	250	3.1 (6.7)	2.5 (5.4)	80
		5.1 (200)	20-21	295	4.0 (8.9)	3.2 (7.1)	81
		6.4 (250)	22-23	330	5.1 (11.2)	4.0 (8.9)	79
		7.6 (300)	23-24	355	6.1 (13.4)	4.8 (10.6)	79
5/64 in (2.0 mm), DC-	19-25 (3/4-1) ⁽⁴⁾	2.3 (90)	18-19	210	2.2 (4.9)	1.8 (4.1)	82
		3.2 (125)	19-20	260	3.2 (7.0)	2.6 (5.6)	81
		3.8 (150)	20-21	300	3.8 (8.4)	3.0 (6.7)	80
		5.1 (200)	21-22	340	5.1 (11.2)	4.1 (9.0)	81
		6.1 (240)	22-23	380	6.1 (13.3)	4.9 (10.8)	81

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer below. ⁽⁴⁾CTWD for 0.072 in. (1.8 mm) and 5/64 in. (2.0 mm) for 200 ipm or greater is 1 in (25 mm).

NOTE: For horizontal welding, subtract 1 volt. NOTE: FEMA and AWS D1.8 structural steel seismic supplement test data can be found on this product at www.lincolnelectric.com/d1.8.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.