

Coreshield 6

Coreshield 6 is a high productivity, high deposition gasless flux cored wire. This self-shielded wire is ideal for single or multiple pass weld applications in addition to providing high deposition rates, low spatter, and good penetration. Because of its stiffer weld puddle, Coreshield 6 offers exceptional multi-pass weld stacking characteristics, produces excellent bead appearance and X-ray quality weld deposits. Coreshield 6 is run DCEP (electrode positive).

Specifications	
Classifications	SFA/AWS A5.20 : E70T-6 SFA/AWS A5.20 : E70T6-A2-CS3-D H8
Approvals	CWB : E492T-6 Seismic Certified : "D"
Industry	Ship/Barge Building Bridge Construction Civil Construction

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	465 MPa (67 ksi)	590 MPa (86 ksi)	26 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	-29 °C (-20 °F)	42 J (31 ft-lb)

Typical Weld Metal Analysis %						
C	Mn	Si	S	P	Ni	Al
0.08	1.26	0.13	0.005	0.013	0.40	0.60

Deposition Data					
Diameter	Current	Voltage	Wire Feed Speed	TTW Dist.	Deposition Rate
2.0 mm (5/64 in.)	275-350 A	23-23.5 V	3.81-6.1 m/min (150-240 in./min)	25.0 mm (1.0, in.)	2.8-4.5 kg/h (6.2-9.9 lbs/h)
2.4 mm (3/32 in.)	270-455 A	22-23 V	2.54-5.7 m/min (100-224 in./min)	25.0 mm (1.0, in.)	2.7-6.5 kg/h (6.0-14. lbs/h)

Recommended Welding Parameters				
Current	Wire Diameter	TTW Dist.	Voltage	Wire Feed Speed
275-390 A	2.0 mm (5/64 in.)	25.4 mm (1 in.)	23-25 V	381-762 cm/min (150-300 in./min)
265-615 A	2.4 mm (3/32 in.)	38 mm (1.5 in.)	22-27 V	254-1016 cm/min (100-400 in./min)