

Coreshield 15

Coreshield 15 is an all-position self-shielded flux cored welding wire for single pass applications. Coreshield 15 produces smooth arc action, full slag coverage, easy slag removal, and low spatter. The use of DCEN (electrode negative) current minimizes the risk of burn-through. Coreshield 15 is excellent for use on lap and fillet welds on thin gauge galvanized and mild steels in all welding positions. The availability of .030" (0.8 mm) diameter makes it possible to use this product on materials as thin as 18 gauge (1.2 mm). The wire is particularly suitable for thin gauge materials 0.030 - 3/16" (0.8-5.0 in.) in galvanized, zinc-aluminum carbon, or aluminised carbon steels. In structural fabrications, the product can be used where no seismic requirements are present.

Specifiche	
Classificazioni	SFA/AWS A5.20 : E71T-14/GS JIS Z 3313 : YFW-S50GB KS D 7104 : YFW-S50GB

Corrente di saldatura	DC-
Tipo di lega	C Mn
Gas di protezione	None

Proprietà tensili tipiche	
Stato	Resistenza alla trazione
Come saldato	614 MPa

analisi tipica del deposito			
C	Mn	Si	Al
0.23	0.70	0.40	1.98

Dati deposito					
Diametro	Amp	Volt	Velocità di trascinamento del filo	Distanza TTW	Tasso di deposito
0.8 mm	75-120 A	14-17 V	2.0-10.0 m/min		0.4-1.8 kg/h
0.9 mm	80-120 A	15-17 V	2.06-9.95 m/min	9.5 mm	0.4-2.0 kg/h
1.2 mm	95-150 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

Parametri di saldatura	
Diametro del filo	
0.8 mm	