

Coreshield 8

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

Specifications	
Classifications	SFA/AWS A5.20 : E71T-8 EN ISO 17632-A : T 42 2 Y N 2
Approvals	ABS : 2YSA H10 BV : S2YM HH CE : EN 13479 CWB : E491T8-A3-CS3-H8 DB : 42.039.35 DNV-GL : II YMS(H10) LR : 2YS H10 UKCA : EN 13479 VdTÜV : 10019

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

Welding Current	DC-
Alloy Type	C Mn
Shielding Gas	None

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
No shielding gas			
As Welded	457 MPa	552 MPa	26 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
No shielding gas		
As Welded	-20 °C	75 J
As Welded	-29 °C	63 J

Typical Weld Metal Analysis %			
C	Mn	Si	Al
No shielding gas			
0.17	0.45	0.12	0.50

Deposition Data					
Diameter	Current	Voltage	Wire Feed Speed	TTW Dist.	Deposition Rate
1.6 mm	135-230 A	18-25 V	3.0-5.8 m/min	13.0 mm	1.77-3.72 kg/h
1.8 mm	150-280 A	18-25 V	2.8-7.1 m/min	19.0 mm	1.86-5.0 kg/h
2.0 mm	175-230 A	18-25 V	3.0-5.8 m/min	19.0 mm	2.18-4.76 kg/h