

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

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
No shielding gas			
As Welded	457 MPa (66 ksi)	552 MPa (80 ksi)	26 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
No shielding gas		
As Welded	-20 °C (-4 °F)	75 J (56 ft-lb)
As Welded	-29 °C (-20 °F)	63 J (47 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Al
No shielding gas			
0.17	0.45	0.12	0.50

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	TTW Dist	Deposition Rate
1.6 mm (1/16 in.)	135-230 A	18-25 V	3.0-5.8 m/min (118-228 in./min)	13.0 mm (0.5, in.)	1.77-3.72 kg/h (3.9-8.2 lbs/h)
1.8 mm	150-280 A	18-25 V	2.8-7.1 m/min (110-280 in./min)	19.0 mm (0.7, in.)	1.86-5.0 kg/h (4.1-11. lbs/h)
2.0 mm (5/64 in.)	175-230 A	18-25 V	3.0-5.8 m/min (118-228 in./min)	19.0 mm (0.7, in.)	2.18-4.76 kg/h (4.8-10.5 lbs/h)