

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 aluminized carbon steels. In structural fabrications, the product can be used where no seismic requirements are present.

Specifications

Classifications	AWS A5.20 : E71T-14 AWS A5.20 : E71T-GS
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Welding Current	DC-
Alloy Type	C Mn
Shielding Gas	None

Typical Tensile Properties

Condition	Tensile Strength
As Welded	614 MPa

Typical Weld Metal Analysis %

C	Mn	Si	Al
0.23	0.70	0.40	1.98

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	TTW Dist.	Deposition Rate
0.8 mm (0.030 in.)	75-120 A	14-17 V	2.0-10.0 m/min (79-394 in./min)		0.4-1.8 kg/h (0.9-4.0 lbs/h)
0.9 mm (0.035 in.)	80-120 A	15-17 V	2.06-9.95 m/min (81-392 in./min)	9.5 mm (0.4 in.)	0.4-2.0 kg/h (0.9-4.4 lbs/h)
1.2 mm (0.045 in.)	95-150 A	15-18 V	1.37-3.56 m/min (54-140 in./min)	12.5 mm (0.5, in.)	0.4-1.2 kg/h (0.9-2.6 lbs/h)
1.6 mm (1/16 in.)	160-275 A	17-19 V	1.42-3.35 m/min (56-132 in./min)	16.0 mm (0.6, in.)	1.0-2.4 kg/h (2.2-5.3 lbs/h)

Recommended Welding Parameters

Wire Diameter
0.8 mm (0.030 in.)