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 galvanised, zinc-aluminum carbon, or aluminised carbon steels. In structural fabrications, the product can be used where no seismic requirements are present.

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

Courant de soudage	DC-
Type d'alliage	C Mn
Gaz de protection	None

Propriétés de traction typiques	
Condition	**Résistance la traction**
Brut de soudage	614 MPa

Analyse du métal déposé			
C	**Mn**	**Si**	**Al**
0.23	0.70	0.40	1.98

Caractéristique de dépôt					
Diamètre	**Ampères**	**Volts**	**Vitesse de dévidage**	**TTW Dist.**	**Taux de dépôt**
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)

Paramètres de soudage
Diamètre du fil
0.8 mm (0.030 in.)