

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 mm) in galvanized, zinc-aluminum carbon, or aluminized carbon steels. In structural fabrications, the product can be used where no seismic requirements are present.

Classifications:	AWS A5.20:E71T-14, AWS A5.36:E71T14-Z-CS3, ASME SFA 5.20, ASME SFA 5.36
Industry or Segmentation:	Civil Construction, Automotive, Industrial and General Fabrication

Typical Tensile Properties

Condition	Tensile Strength
As Welded	615 MPa (89 ksi)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Al
0.24	0.58	0.23	0.002	0.012	1.53

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate	TTW Dist.	Efficiency
0.9 mm (.035 in.)	120 A	17 V	394 cm/min (155 in./min)	0.77 kg/h (1.7 lb/h)	9.5 mm (3/8 in.)	77 %
0.9 mm (.035 in.)	200 A	17 V	995 cm/min (392 in./min)	2.04 kg/h (4.5 lb/h)	9.5 mm (3/8 in.)	81 %
0.9 mm (.035 in.)	80 A	15 V	206 cm/min (81 in./min)	0.41 kg/h (0.9 lb/h)	9.5 mm (3/8 in.)	75 %
1.2 mm (.045 in.)	150 A	17 V	300 cm/min (118 in./min)	0.95 kg/h (2.1 lb/h)	12.5 mm (1/2 in.)	79 %
1.2 mm (.045 in.)	225 A	18 V	356 cm/min (140 in./min)	1.18 kg/h (2.6 lb/h)	12.5 mm (1/2 in.)	82 %
1.2 mm (.045 in.)	95 A	15 V	137 cm/min (54 in./min)	0.41 kg/h (0.9 lb/h)	12.5 mm (1/2 in.)	74 %
1.6 mm (1/16 in.)	160 A	17 V	142 cm/min (56 in./min)	0.95 kg/h (2.1 lb/h)	16 mm (5/8 in.)	78 %
1.6 mm (1/16 in.)	200 A	18 V	193 cm/min (76 in./min)	1.32 kg/h (2.9 lb/h)	16 mm (5/8 in.)	80 %
1.6 mm (1/16 in.)	275 A	19 V	335 cm/min (132 in./min)	2.35 kg/h (5.2 lb/h)	16 mm (5/8 in.)	81 %