



Product Data Sheet

T 'Tubular cored electrode arc welding'

Coreshield 15

Prepared by Neil Farrow	Qualified by Tero Borg	Approved by Neil Farrow	Reg no EN007013	Cancelling EN003888	Reg date 2016-01-25	Page 1 (1)
----------------------------	---------------------------	----------------------------	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

Typical mechanical values added

GENERAL

An all positional self-shielded cored wire. Designed for the welding of thin gauge steel.

Shielding Gas: None

Alloy Type: C Mn

Polarity: DC-

Fill Type: Self-shielded

CLASSIFICATIONS Weld Metal

APPROVALS

SFA/AWS A5.20 E71T-GS

Not applicable

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.15	0.35
Si	0.10	0.50
Mn	0.50	1.20
P		0.030
S		0.030
Al	1.60	2.90

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	As welded	
	Min	Typ
Rm (MPa)	497	614

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H	Feed		U	
	Min	Max	Nom	Nom	Min	Max	Min	Max	Max
\emptyset									
0.8	40	100		78			3.0	7.0	14

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)