

CORESHIELD 8 AWS A5.20: E71T-8

FEATURES

Coreshield 8 is a self-shielded flux cored wire designed to weld critical structural applications while maintaining excellent arc characteristics and high welder appeal. Coreshield 8 is tested and certified to meet the new AWS D designation requirements, making this self-shielded wire an excellent choice for demand critical welds when the AWS D1.8 Seismic Supplement is utilized.

TYPICAL MECHANICAL PROPERTIES

As Welded

Yield Strength	67 ksi, 465 MPa
Tensile Strength	82 ksi, 565 MPa
Elongation in 2"	24%

CLASSIFICATIONS AND APPROVALS

- Seismic Certified "D"
- AWS A5.20: E71T-8
- ASME SFA 5.20
- CERTIFIED BY C.W.B. - CSA W48
- A.B.S.- 3SA,3YSA(H10)
- D.N.V.- III YMS(H10)
- L.R.- 3S,3YS(H10)
- B.V.- S3YM(HH)
- TUV
- GL
- DEUTSCHE BAHN

CHARPY V-NOTCH PROPERTIES

Testing Temperature -20°F (-29°C)

30 ft-lb, 41 J

Testing Temperature 40°F (4°C)

65 ft-lb, 85 J

WELDING PROCESS

- FCAW (Flux Core)

INDUSTRIES

- Mobile Machinery
- Bridge Construction
- Civil Construction
- Shipbuilding
- General Fabrication

WELD METAL ANALYSIS

C	0.17%
Mn	0.5%
Si	0.1%
P	0.010%
S	0.003%
Al	0.5%

CORESHIELD 8 continued

DEPOSITION TABLE -						
Diameter in (mm)	Amps	Volts	Wire Feed Speed ipm (cm/min)	Deposition lb/hr (kg/hr)	Efficiency %	Electrical Stickout in (mm)
1/16 (1.6)	155	21	150 (381)	4.16 (1.9)	78.6	1/2 (12.7)
	180	22	185 (470)	5.14 (2.3)	79.6	1/2 (12.7)
	205	24	240 (610)	6.60 (3.0)	78.2	1/2 (12.7)
	220	25	275 (698)	7.53 (3.4)	78.9	1/2 (12.7)
0.072 (1.8)	200	21	160 (406)	6.13 (2.8)	79.4	1/2 (12.7)
	225	21	190 (483)	7.32 (3.3)	80.3	1/2 (12.7)
5/64 (2.0)	150	21	90 (229)	3.96 (1.8)	80.6	3/4 (19)
	175	22	110 (279)	4.83 (2.2)	80.9	3/4 (19)
	200	23	135 (343)	5.93 (2.7)	80.4	3/4 (19)

FULL RANGE WELDING PARAMETERS							
1/16"				.072"			
WFS ipm	Volts	Amps	Tip to Work in	WFS ipm	Volts	Amps	Tip to Work in
125	18.0	160	1/2-3/4	100	18.0	160	3/4-1
150	19.0	180	1/2-3/4	130	19.0	205	3/4-1
185	19.0	200	1/2-3/4	160	20.0	230	3/4-1
240	20.0	230	1/2-3/4	190	21.0	260	3/4-1
275	22.0	250	1/2-3/4	220	22.0	275	3/4-1

CORESHIELD 8 continued

FULL RANGE WELDING PARAMETERS

5/64"			
WFS	Volts	Amps	Tip to Work
90	18.0	170	3/4-1
110	19.0	190	3/4-1
135	20.0	220	3/4-1
150	21.0	250	3/4-1
175	22.0	275	3/4-1
200	23.0	285	3/4-1

PART NUMBER / PRODUCT INFORMATION

Part Number	Description	UPC
242206126	CS 8 1/16X20#AWS	662303081539
242206357	CS 8 1/16X25#AWS	662303053420
242206399	CS 8 1/16X25#AWS VP	662303070106
242206258	CS 8 1/16X50#CL	662303042707
242206134	CS 8 072X20#AWS	662303081546
242206365	CS 8 072X25#AWS	662303053437
242206423	CS 8 072X25#AWS VP	662303070120
242206266	CS 8 072X50#CL	662303053215
242206142	CS 8 5/64X20#AWS	662303081553
242206373	CS 8 5/64X25#AWS	662303053444
242206415	CS 8 5/64X25#AWS VP	662303070113
242206274	CS 8 5/64X50#CL	662303053222