

Innershield® NR®-212

TOP FEATURES

- Accommodates a wide range of mild steels
- Fast freeze characteristics accommodate poor fit-up
- Smooth arc performance
- Ease of use

TYPICAL APPLICATIONS

- Single or multiple pass welding on up to 19 mm (3/4 in) thicknesses
- Truck bodies, tanks, hoppers, racks and scaffolding
- General fabrication
- Robotics

CLASSIFICATION

AWS A5.29 E71TG-G

WELDING POSITIONS

All

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Al	Ni	HDM
0.06-0.11	0.84-1.55	0.20-0.33	0.006-0.009	<0.03	1.3-1.6	1.02-1.15	16 ml/100g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Hardness Rockwell B
Required: AWS 5.29		min. 400	480-655	min. 20	not specified
Typical values	AW	440-505	575-6-5	24-28	89-92

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.1	SPOOL	4.5	ED026090
	SPOOL	11.3	ED030639
1.7	SPOOL	3.6	ED037028
	COIL	6.4	ED027803
	SPOOL	11.3	ED030642
2.0	COIL	6.4	ED027794
	SPOOL	11.3	ED030646
	COIL	22.7	ED026858

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.