

## Coreshield 8

Coreshield 8 is a self-shielded flux cored wire designed to weld critical structural applications while maintaining excellent arc characteristics and high welder appeal using DCEN polarity. 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

|                                    |   |
|------------------------------------|---|
| <b>Classifications Weld Metal:</b> | SFA/AWS A5.20:E71T-8, EN ISO 17632-A:T 42 2 Y N 2   |
| <b>Approvals:</b>                  | CE EN 13479, GL 3YS, ABS 3YSA H10, NAKS/HAKC 1.6MM, BV SA3YM H10, CWB E491T-8-H16, DB 42.039.35, DNV III YMS H10, LR 3YS H10, VdTÜV 10019 |

Approvals are based on factory location. Please contact ESAB for more information.

|                         |      |
|-------------------------|------|
| <b>Welding Current:</b> | DC-  |
| <b>Alloy Type:</b>      | C Mn |

### Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|-----------|----------------|------------------|------------|
| As welded | 457 MPa        | 552 MPa          | 26 %       |

### Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|-----------|---------------------|--------------|
| As welded | -20 °C              | 75 J         |
| As welded | -29 °C              | 63 J         |

### Typical Weld Metal Analysis %

| C    | Mn   | Si   | Al   |
|------|------|------|------|
| 0.17 | 0.45 | 0.12 | 0.50 |

### Deposition Data

| Diameter | Current   | Voltage | Wire Feed Speed | Deposition Rate |
|----------|-----------|---------|-----------------|-----------------|
| 1.6 mm   | 155-240 A | 21-25 V | 3.8-7.6 m/min   | 1.9-3.7 kg/h    |