Revishield® 71T8-Ni1

Self-shielded cored wire

Classification

AWS A5.29/A5.29M :E71T8-Ni1

General description

Self shielded: easiest equipment arrangement
All position welding
Easy to weld in vertical up position
All passes
Good impact and CTOD toughness

Welding positions

ISO/ASME	PA/1G	PB/2F	PC/2G	PF/3G up	PG/3G down	PE/4G	PF/5G up	PG/5G down

Current type / Shielding gases

DC -

Approvals

ABS	BV	DNV	FORCE	GL	LR	RINA	TÜV
3SA, 3YSA	SA3YMHH	IIIYMSH10	+	3YSH10	3S, 3YSH15	3S, 3YS	+

Typical chemical composition of all weld metal, (w%)

C	Mn	Si	P	S	Al	Ni
0.8	1.1	0.27	0.008	0.003	0.85	0.9

Mechanical properties of all weld metal

		Shielding gas	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact (ISO), J	
							+20°C	-29°C
Required	AWS A5.29			min 400	480-620	20		27
Typical values after welding			AW	465	540	26		115

Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm) 2.0	2.4
Coils 14C	6.35	X	
Coils 50C	22.8	X	X

Identification Imprint: Revishield®71T8 Ni1

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Suggestions for use

For mild and higher strength steel, not exceeding the yield strength range of the electrode weld deposit
General plate fabrication, including bridge construction, hull plate and stiffener welding on ships and barges, off shore
For semi- and full automatic welding

Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S185, S235, S275, S355
Ship plates	ASTM 131	Grade A, B, D, AH32 to DH36
Cast steel	EN 10213-3	GP240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240, L290, L360
	API 5LX	X42, X46, X52
	EN 10216-1/	P235T1, P235T2, P275T1
	EN 10217-1	P275T2, P355N
Boiler & pressure vessel steel	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steel	EN 10113-2	S275, S355
	EN 10113-3	S275, S355

Calculation data

Diameter mm	Electrode Stick-out (mm)	Wire feed speed cm/min	Current (A)	Voltage (B)	Deposition Rate (kg/h)	kg Wire/kg weld metal
2.0	19	125	145	16	1.10	1.30
		230	235	20	1.95	1.30
		355	310	23	3.15	1.30
2.4	19	125	215	18	1.60	1.20
		240	315	21	3.25	1.20
		330	385	24	4.30	1.20

Welding parameters, optimum fill

Diameter (mm)	Current / Voltage	Welding position						
		PA/1G	PB/2F	PC/2G	PF/3Gup	PF/5G up	PG/3G down PG/5G down	PE/4G
2.0	(A)	255	300	235	215	215	215	195
	(V)	21	22	20	19	19	18	19
2.4	(A)	345	345	290	250			
	(V)	22	22	19.5	19			