

Self-shielded cored wire

Classification

AWS A5.26/A5.26M :E91T8-G

General description

Revishield® 72T-1 is an Revishield consumable used for electrogas welding (EGW)
 Vertishield is the Wutmarc name for its vertical-up, self-shielded, single pass electrogas arc welding process
 This process does not use an external shielding gas
 Vertishield welds are made by two methods: the consumable guide and the moving shoe process

Welding positions



ISO/ASME PF/3G up

Current type / Shielding gases

DC +

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

The chemical composition of the welds will change with different heats of steel

Mechanical properties of all weld metal

		Shielding Condition gas	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact (ISO), J -27°C
Required	AWS A5.26		min 345	483-655	22	20
Typical values after welding						

Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm)
Coils 50C	22±8	X

Identification Imprint: Revishield®72T-1

Revishield®72T-1: rev. EN 20

Suggestions for use

The moving shoe (dam) welding can be used with either a gapped V-groove or square butt plate
Material from 9.5 to 100 mm plate thickness and unlimited length can be welded
The consumable guide process is intended to weld joints less than three feet long
Copper retaining dams extend the full length of the joint

Materials to be welded

Steel	Code	Type
General structural steel		S185, S235, S275, S355
Ship plates	ASTM A131	Grade A, B, D, AH32 to DH36

Calculation data

Diameter mm	Electrode Stick-out (mm)	Wire feed speed cm/min	Current (A)	Arc Voltage (B)	Deposition Rate (kg/h)	kg Wire/kg weld metal
2.4	38	250	635	390-430	34	9
		300	760	435-465	36	11
		350	890	480-520	37	13
		400	1020	530-570	39	15