



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

Classifications	AWS A5.20 : E71T-8 JD-H8 AWS A5.36 : E71T8-A2-CS3-H8 ASME SFA 5.36 ASME SFA 5.20
Approvals	DB Seismic Certified "D" BV LR DNV-GL ABS CWB CSA W48 E491T-8-H8

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

Welding Current	DC-
Alloy Type	C Mn

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	465 MPa (67 ksi)	565 MPa (82 ksi)	24 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-29 °C (-20 °F)	41 J (30 ft-lb)
As Welded	4 °C (40 °F)	85 J (65 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Al
0.19	0.44	0.15	0.003	0.010	0.51

Deposition Data

Diameter	Current	Wire Feed Speed	Deposition Rate	Deposition Efficiency %
1.8 mm (0.072 in.)	200 A	406 cm/min (160 in./min)	2.8 kg/h (6.13 lb/h)	79.4 %
1.8 mm (0.072 in.)	225 A	483 cm/min (190 in./min)	3.3 kg/h (7.32 lb/h)	80.3 %
1.6 mm (1/16 in.)	155 A	381 cm/min (150 in./min)	1.9 kg/h (4.16 lb/h)	78.6 %
1.6 mm (1/16 in.)	180 A	470 cm/min (185 in./min)	2.3 kg/h (5.14 lb/h)	79.6 %
1.6 mm (1/16 in.)	205 A	610 cm/min (240 in./min)	3.0 kg/h (6.60 lb/h)	78.2 %
1.6 mm (1/16 in.)	220 A	698 cm/min (275 in./min)	3.4 kg/h (7.53 lb/h)	78.9 %
2.0 mm (5/64 in.)	150 A	229 cm/min (90 in./min)	1.8 kg/h (3.96 lb/h)	80.6 %
2.0 mm (5/64 in.)	175 A	279 cm/min (110 in./min)	2.2 kg/h (4.83 lb/h)	80.9 %
2.0 mm (5/64 in.)	200 A	343 cm/min (135 in./min)	2.7 kg/h (5.93 lb/h)	80.4 %