



# Coreshield 15

Coreshield 15 is an all-position self-shielded flux cored welding wire for single pass applications. Coreshield 15 produces smooth arc action, full slag coverage, easy slag removal, and low spatter. The use of DCEN (electrode negative) current minimizes the risk of burn-through. Coreshield 15 is excellent for use on lap and fillet welds on thin gauge galvanized and mild steels in all welding positions. The availability of .030" (0.8 mm) diameter makes it possible to use this product on materials as thin as 18 gauge (1.2 mm). The wire is particularly suitable for thin gauge materials 0.030 - 3/16" (0.8-5.0 in.) in galvanized, zinc-aluminum carbon, or aluminised carbon steels. In structural fabrications, the product can be used where no seismic requirements are present.

<b>Classifications</b>	AWS A5.20 : E71T-GS AWS A5.20 : E71T-14
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<b>Welding Current</b>	DC-
<b>Alloy Type</b>	C Mn

## Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate	TTW Dist.	Deposition Efficiency %
0.9 mm (.035 in.)	120 A	17 V	394 cm/min (155 in./min)	.77 kg/h (1.7 lb/h)	-	77 %
0.9 mm (.035 in.)	200 A	17 V	995 cm/min (392 in./min)	2.04 kg/h (4.5 lb/h)	-	81 %
0.9 mm (.035 in.)	80 A	15 V	206 cm/min (81 in./min)	.41 kg/h (.9 lb/h)	-	75 %
1.2 mm (.045 in.)	150 A	17 V	300 cm/min (118 in./min)	.95 kg/h (2.1 lb/h)	-	79 %
1.2 mm (.045 in.)	225 A	18 V	356 cm/min (140 in./min)	1.18 kg/h (2.6 lb/h)	-	82 %
1.2 mm (.045 in.)	95 A	15 V	137 cm/min (54 in./min)	.41 kg/h (.9 lb/h)	-	74 %
1.6 mm (1/16 in.)	160 A	17 V	142 cm/min (56 in./min)	.95 kg/h (2.1 lb/h)	-	78 %
1.6 mm (1/16 in.)	200 A	18 V	193 cm/min (76 in./min)	1.32 kg/h (2.9 lb/h)	-	80 %
1.6 mm (1/16 in.)	275 A	19 V	335 cm/min (132 in./min)	2.35 kg/h (5.2 lb/h)	-	81 %
0.8 mm (.030 in.)	40 A	15 V	175 cm/min (69 in./min)	-	9.5 mm (3/8 in.)	-
0.8 mm (.030 in.)	100 A	16 V	444.5 cm/min (175 in./min)	-	9.5 mm (3/8 in.)	-
0.8 mm (.030 in.)	160 A	16 V	1118 cm/min (440 in./min)	-	9.5 mm (3/8 in.)	-
0.9 mm (.035 in.)	80 A	15 V	206 cm/min (81 in./min)	-	9.5 mm (3/8 in.)	-
0.9 mm (.035 in.)	120 A	17 V	394 cm/min (155 in./min)	-	9.5 mm (3/8 in.)	-
0.9 mm (.035 in.)	200 A	17 V	996 cm/min (392 in./min)	-	9.5 mm (3/8 in.)	-
1.2 mm (.045 in.)	95 A	15 V	137 cm/min (54 in./min)	-	12.5 mm (1/2 in.)	-
1.2 mm (.045 in.)	150 A	17 V	300 cm/min (118 in./min)	-	12.5 mm (1/2 in.)	-
1.2 mm (.045 in.)	225 A	18 V	356 cm/min (140 in./min)	-	12.5 mm (1/2 in.)	-
1.6 mm (1/16 in.)	160 A	17 V	142 cm/min (56 in./min)	-	16 mm (5/8 in.)	-
1.6 mm (1/16 in.)	200 A	18 V	193 cm/min (76 in./min)	-	16 mm (5/8 in.)	-
1.6 mm (1/16 in.)	275 A	19 V	335 cm/min (132 in./min)	-	16 mm (5/8 in.)	-
2.0 mm (5/64 in.)	185 A	19 V	127 cm/min (50 in./min)	-	25.4 mm (1 in.)	-
2.0 mm (5/64 in.)	250 A	20 V	231 cm/min (91 in./min)	-	25.4 mm (1 in.)	-
2.0 mm (5/64 in.)	300 A	21 V	343 cm/min (135 in./min)	-	25.4 mm (1 in.)	-



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### Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
0.8 mm (0.030 in.)	40-100 A	14-16 V	3.0-7.0 m/min (118-276 in./min)