

# Supershield 71-T8

Type : Self-shielded



### Conformances

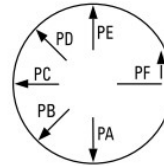
AWS A5.36 / ASME SFA5.36 E71T8-A2-CS3 H8  
(AWS A5.20 / ASME SFA5.20 E71T-8 H8)  
EN ISO 17632-A-T 42 3 Y NO 2 H10

CE

### Applications

- General fabrication
- Bridge & Civil construction
- Shipbuilding
- AWS D1.8 Seismic requirements

### Welding Position



### Features

- Excellent mechanical properties
- Easy slag removal
- Excellent resistance to cracking
- Suitable for outdoor welding

### Current

DC -

### Shielding Gas

No shielding gas

### Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Al
0.16	0.15	0.63	0.003	0.003	0.48

### Typical Mechanical Properties of All-Weld Metal

YS Mpa(lbs/in <sup>2</sup> )	TS Mpa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.lbs)
447 (64,800)	565 (82,000)	32	-30 (-22)	65 (48)

### Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)
<b>1.6mm (1/16 in) DC-</b>						
No shielding gas	25 (1)	4.0 (160)	190-220	18-21	1.7 (3.7)	75-79
		4.8 (190)	210-240	20-22	2.0 (4.4)	
		5.4 (215)	230-260	21-23	2.4 (5.2)	
		6.4 (255)	250-280	22-23	2.7 (5.9)	
<b>1.8mm (0.072 in) DC-</b>						
No shielding gas	25 (1)	3.8 (150)	220-250	21-23	2.6 (5.7)	79-83
		4.3 (170)	250-280	22-23	2.9 (6.3)	
		5.4 (215)	280-310	23-24	3.7 (8.1)	
<b>2.0mm (5/64 in) DC-</b>						
No shielding gas	25 (1)	3.0 (120)	230-260	21-23	2.4 (5.2)	77-81
		3.9 (155)	260-290	22-23	3.0 (6.6)	
		5.2 (205)	290-320	23-24	3.8 (8.3)	

Diam.	12.5 kg Spool
1.6mm	HKT816
1.8mm	HKT818
2.0mm	HKT820

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