

# Innershield® NS-3M

## Key Features

- Very high deposition rates
- Increased resistance to hydrogen cracking and porosity
- Soft low penetrating arc for minimal base material dilution

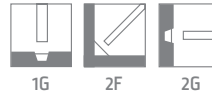
## Typical Applications

- Open groove welds
- Machinery bases and heavy equipment repair
- Installing wear plates
- 6.5-13 mm single pass fillet / lap welds

## Conformances

AWS A5.20/A5.20M: E70T-4

## Welding Positions



## Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts*	Current amps	CTWD mm
2.0	ED030651	Coil 11.3kg	200-300	29-33	280-350	50-55
2.0	ED012740	Coil 22.7kg	200-300	29-33	280-350	50-55
2.4	ED012736	Coil 22.7kg	110-275	28-34	250-450	70-75
3.0	ED012731	Speed-Feed® Drum 272kg	140-355	28-40	380-600	70-100
3.0	ED012732	Coil 22.7kg	140-355	28-40	380-600	70-100

\*Polarity DC+

## Mechanical Properties - As required per AWS A5.20

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Hardness HRB
Requirements - AWS E70T-4	390 min	490-670	22 min	-
Typical Results - As Welded	415-450	580-620	25-28	87-91

## Deposit Composition

	%C	%Mn	%Si	%S	%P	%AL
AWS Requirements	0.30 max	1.75 max	0.60 max	0.03 max	0.03 max	1.8 max
Typical Results	0.21-0.25	0.37-0.53	0.25-0.29	≤0.01	≤0.01	1.3-1.6