

# Coreshield 15

AWS A5.20 E71T-G5 / JIS Z3313 YFW-S506B

## Description

- Coreshield 15 is a self-shielded all-position flux cored welding wire for single pass applications. It is excellent for use on thin gauges of galvanized and mild steels. Travel speed is high and weld edges are smooth. Coreshield 15 has a smooth arc action, full slag coverage, easy slag removal, and low spatter. No shielding gas is required. The use of DC straight polarity welding current minimizes the risk of burn through. Deposition efficiency is higher than that of shielded metal arc electrodes.

## Application

- 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" diameter wire makes it possible to use this product on materials as thin as 18 gauge.

## Typical Mechanical Properties of All Weld Metal

Transverse Tension Test N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Longitudinal Guided Bend Test
520 {53}	No Defects

## Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Al
0.25	0.65	0.40	0.010	0.006	2.40

## Special Precautions

- Coreshield 15, like many other similar self-shielded electrodes, contains fluoride compounds. The fume exposure limit for fluorides is 2.5mg/m<sup>3</sup> as Fluoride (Permissible Exposure Limit per Occupational Safety and Health Administration.) Coreshield 15, or any other welding electrode, requires extra attention to ventilation when being used to weld galvanized steel. Freshly formed zinc oxide, when inhaled, can cause metal fume fever. This ailment is unpleasant and is characterized by, chills, breathing difficulty, fever, cough, muscular pain, nausea, and vomiting. It resembles a bad case of influenza in symptoms. These symptoms will disappear within 48 hours of the time when exposure to freshly formed zinc oxide ceases.