

Coreshield 7

AWS A5.20 E70T-7 / JIS Z3313 YFW-S50GB

Description

- Coreshield 7 is a self-shielded flux cored wire designed for single and multipass welding of mild steel base plate. It should only be run on straight polarity (Electrode Negative). Sheet as thin as 10 gauge can be welded with 1/16" Coreshield 7. Welding in the flat, horizontal, and vertical-down positions is possible with the 1/16" diameter. The larger diameters are for use in the flat and horizontal positions.

Application

- Coreshield 7 should be used for general structural steel welding where self-shield provides an advantage. If it is to be used indoors, some provision for fume removal will normally be necessary. Coreshield 7 is not recommended for weldments where impact toughness testing is specified.

Typical Mechanical Properties of All Weld Metal

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)
440 {45}	660 {61}	26

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Al
0.20	0.30	0.25	0.007	0.002	1.10

Special Precautions

- Coreshield 7, like many other E70T-7 wires, contains fluoride compounds. The fume exposure limit for fluorides is 2.5mg/m³ as Fluoride (Permissible Exposure Limit per Occupational Safety and Health Administration 29 CFR 1910.1000). This limit may be reached before the general fume limit of 5mg/M³ is reached (The shold Limit Value, per American Conference of Governmental Industrial Hygienists.)