CIGWELD

AN ESAB BRAND

GASLESS



SHIELD-COR XT8

GASLESS WELDING WIRE

PRODUCT DATA SHEET

ALL POSITIONAL MULTI PASS E71T-8 WIRE



SELF-SHIELDED FLUX CORED ARC WELDING (FCAW) WIRES

SHIELD-COR XT8:

- Self-shielded Flux Cored wire.
- For single or multi pass applications.
- Versatile, all Positional Capabilities.
- Excellent operator appeal.
- Smooth Rippled Fillets with good Edge Wetting.
- Ideal for welding Mild and medium strength plate and pipes.

CLASSIFICATIONS:

ISO AS/NZS: 17632	**B T 49 2 T81 1 NA U H10**
AWS/ASME-SFA A5.20:	**E71T-8**

RECOMMENDED SHIELDING GAS:

Not Required.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	**413 MPa**
Tensile Strength	**589 MPa**
Elongation	**26%**
Impact	**50J @ -30°C**

TYPICAL ALL WELD METAL ANALYSIS:

Single values are maximum allowable, unless otherwise stated.

C:	**0.22%**
Mn:	**0.65%**
Si:	**0.33%**
Al:	**0.71%**
S:	**0.002%**
P:	**0.018%**

CIGWELD Data Sheet **SHIELD-COR XT8** V1-2026
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DESCRIPTION AND APPLICATIONS:

Shield-Cor XT8 is a self-shielding rutile type flux cored welding wire for the joining of mild and medium strength plate and pipes in all positions.

Shield-Cor XT8 meets the performance requirements of AWS A5.20: E71T-8 and when used with DC electrode negative polarity produces smooth arc characteristics with low spatter and an easy-to-remove full covering slag.

The superior all positional performance of Shield-Cor XT8 makes it the prime choice for structural steel work and tank building where wires requiring shielding gas cannot be used. Stringer bead or weave techniques are equally suitable for use with this wire. The outstanding operator appeal of Shield-Cor XT8 make it the optimum choice for operators of all skill levels and experience. The user-friendly nature of Shield-Cor XT8 is backed up by impressive all weld metal mechanical properties and superior deposition rates to that of comparable wires in this class.

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

8.0 - 8.5 mls of hydrogen / 100gms of deposited weld metal*.

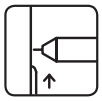
*- for “as manufactured” product using the recommended E.S.O. lengths.

PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
1.6	Spool	15kg	722016
1.8	Spool	15kg	722018
2.0	Spool	15kg	722020

OPERATING DATA:

All welding conditions recommended below are for use with semi-automatic operation, and DC electrode negative polarity.

WIRE DIAMETER (MM)	CURRENT RANGE (AMPS)	VOLTAGE RANGE (VOLTS)	CTWD	WELDING POSITION
1.6	170-250	20-24	15-25	 Flat
1.8	195-270	21-25	15-25	
2.0	220-290	22-26	20-30	
1.6	170-260	20-24	15-25	 HV Fillet
1.8	185-270	21-25	15-25	
2.0	200-280	22-26	20-30	
1.6	150-220	20-24	15-25	 Vertical Up
1.8	165-230	21-25	15-25	
2.0	180-240	22-26	20-30	
1.6	150-220	21-25	12-20	 Overhead
1.8	175-230	21-25	15-25	
2.0	200-240	22-26	15-25	

These machine settings are a guide only. Actual voltage, welding current and CTWD used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

