

Innershield® NS-3M

TOP FEATURES

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

TYPICAL APPLICATIONS

- Open groove welds
- Machinery bases and heavy equipment repair
- Installing wear plates
- 6.4 - 12.7 mm (1/4 - 1/2 in) single pass fillet and lap welds

CLASSIFICATION

AWS	E70T-4
	E70T4-AZ-CS3
EN ISO 17632-A	T 38 Z V N 3

CURRENT TYPE

DC+

WELDING POSITIONS

Flat/Horizontal

APPROVALS

DB

+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Al
0.20-0.27	0.35-0.45	0.26-0.30	0.011	0.004	1.30-1.50

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)
Required: AWS A5.20		400	480-660	22
Typical values	AW	410	570-640	23

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
2.0	COIL	6.4	ED012739
	COIL	22.7	ED012740
2.4	COIL	22.7	ED012736
	DRUM	272.0	ED012735
3.0	COIL	22.7	ED012732
	DRUM	272.0	ED012731

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.