

TYPE : Self-Shielded

Applications

- ① Supershield EG-82T is used for Vertical-up, self-shielded, V-groove & Square Butt joint single pass electrogas arc welding process of Storage tank fabrication,
- ② It is suitable for welding of mild steel, Ship plate and Pressure vessel steel with high deposition rate.

Characteristics on Usage

- ① Supershield EG-82T is an Self-shielded Flux cored consumable used for electrogas arc welding process (EGW).

Notes on Usage

- ① This process does not use an external shielding gas.
- ② Use DC(+) polarity.

Welding Position

Current



DC +

1G (PA) 2F (PB) 3G (PF) 4G (PE)

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Mo
0.05	0.26	1.50	0.009	0.010	0.35

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
550 (79,800)	640 (92,800)	25.0	-30 (-22)	55 (41)

Approval

I Packing

Dia. (mm) 2.4 Spool(kg) 25
(in) 3/32 (lbs) 55

Sizes Available and Recommended Currents (Amp.)

Diameter in(mm)	Electrical Stick-out in(mm)	Wire feed speed		Current (approx. A)	Arc Voltage (V)	Deposition Rate (kg/h)
		inch / min	cm / min			
3/32 (2.4)	1.49 (38)	250	635	380~450	34	10
		300	760	450~480	36	12
		350	890	480~550	38	15
		400	1020	550~600	45	16