Outershield® 71E-H

TOP FEATURES

- Rutile flux cored wire for high quality welding with M21 gas
- Excellent operator appeal due to superior welding characteristics
- Superior product consistency with optimal alloy control
- H4 class in 1.6mm diameter
- Full out-of-position capability with high deposition rates

TYPICAL APPLICATIONS

- Shipbuilding
- Steel construction
- HYPERFILL

CLASSIFICATION

AWS A5.20	E71T-1M-J
	E71T-1C-H4
EN ISO 17632-A	T 46 3 P M21 1 H5
	T 42 0 P C1 1 H5
	T 46 3 P M20 1 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All positions

APPROVALS

ABS, LR, BV, DNV, RINA, TÜV, CWB

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO_2
M20	Mixed gas Ar+ 5-15% CO_2
C1	Active gas 100% CO_2
Gas flow	15-25l/min

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

Shielding gas	C	Mn	Si	P	S	HDM
M21	0.04	1.4	0.6	0.013	0.010	3 ml/100 g
C1	0.05	1.3	0.6	0.015	0.010	3 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) 0°C	-20°C	-30°C	-40°C
Required: AWS A5.20		-	min. 400	min. 480	min. 22	-	-	-	min. 27
EN ISO 17632-A		-	min. 460	530-680	min. 20	-	-	min. 47	
Typical values	M21	AW	570	620	25	-	90	65	40
	C1	AW	520	575	24	80	-	-	-

AW = As-welded

- = not specified

AVAILABLE SIZES AND PACKAGING INFORMATION

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S200)	5.0	900125
	SPOOL (B300)	16.0	900156N
	SPOOL (S300)	16.0	900149NE
	DRUM	200.0	900297
1.6	SPOOL (S300)	16.0	900262NE

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.