

Outershield® 71E-H

Key Features

- Class leading welding performance
- Excellent mechanical properties with very low hydrogen levels H4/H5
- All positional rutile wire designed for welding with mixed gases and 100% CO₂ shielding gas
- Vacuum sealed aluminium foil bag packaging, precision layer wound wire

Conformances

AWS A5.20/A5.20M: E71T-1M / E71T-9M J* H4
E71T-1C H4

*Applies to 1.2mm size only

AS/NZS ISO 17632-A: T 46 3 P M 1 H5

AS/NZS ISO 17632-B: T 49 3 T1-1 M A K U H5

M21 **C1**

Lloyds Register 3YSH5

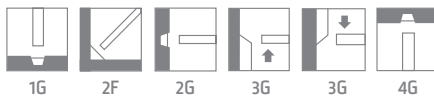
ABS 3YSAH5

DNV III Y40MS (H5) III Y40(H5)

Typical Applications

- Welding prequalified procedures for steel groups 1-7C according to AS/NZS 1554.1 Table 4.6.
- Full out of position welding requiring good penetration and high deposition rates
- General structural fabrication, mining, building, shipbuilding, etc.
- C-Mn plate to 450 MPa yield strength
- Root runs on ceramic backing

Welding Positions



Shielding Gas

- 75-85% Argon / 15-25% CO₂
- 100% CO₂
- Flow Rate: 15-25L/min

Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts	Current amps	CTWD mm
1.2	900149NE	S300 VFB 16kg	175-600	21-31	130-300	15-20
1.2	900125	S200 VFB 5kg	175-600	21-31	130-300	15-20
1.6	900262NE	S300 VFB 16kg	130-400	21-31	170-400	15-20

Mechanical Properties - As required per AWS A5.20

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -40°C
Requirements - AWS E71T-1M, E71T-9M. As Welded with M21 gas	390 min	490-670	22 min	27 min
Typical Results (1.2mm)	570	620	25	40

Deposit Composition

	%C	%Mn	%Si	%P	%S	Diffusible Hydrogen
Typical Results - with M21 gas	0.04	1.40	0.60	0.013	0.010	3 ml / 100 g