Outershield® MC715-H

Key Features

- All position (1.2mm only) high efficiency gas shielded metal cored wire
- Excellent arc characteristics provide outstanding operator appeal and mechanical properties
- Minimal spatter, fast travel speed, excellent wire feeding
- Superior product consistency with optimal alloy control
- Depending on application, good alternative to basic (T-5) flux cored wires

Typical Applications

- Welding prequalified procedures for steel groups 1-7C according to AS/NZS 1554.1 Table 4.6.1.
- Structural fabrication
- Heavy equipment
- General fabrication
- Robotics / hard automation

Conformances

AWS A5.18/A5.18M:	E70C-6M H4
AS/NZS ISO 17632-A:	T 46 4 M M 2 H5
AS/NZS ISO 17632-B:	T 49 4 T15-1 M A K U H5
DNV:	IV Y40H5
BV:	SA3, 3YMHH

Welding Positions

Shielding Gas

- 75-85% Argon / 15-25% CO_2
- 90% Argon / 10% CO_2
- Flow Rate: 15-25 L/min

Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts	Current amps	CTWD mm
1.2	900429NE	Spool S300 16kg VFB	100 - 550	15-33	120-340	15-20
1.6	900470N	Spool S300 16kg VFB	150 - 450	27-34	200-450	15-25

Mechanical Properties - As required per AWS A5.18

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -30°C
Requirements - AWS E70C-6M As Welded with M21 gas	400 min	480 min	22 min	27 min
Typical Results	480	580	27	110 at -40°C

Deposit Composition

	%C	%Mn	%Si	%S	%P	Diffusible Hydrogen
Typical Results	0.04	1.5	0.4	0.020	0.012	3 ml / 100 g