

# Outershield® MC715-H

## TOP FEATURES

- High deposition rate and excellent weldability. Low amount of silicates. Suitable for single and multipass automatic welding.
- Excellent arc characteristics give outstanding operator appeal.
- Excellent mechanical properties (CNV >47) at -40°C).
- Very good weldability with short, pulsed and spray arc. Suitable for robotic applications. Bridging and root passing capabilities with short and pulsed arc.
- Applicable for welding of flanges of wind mill towers.

## TYPICAL APPLICATIONS

- Steel construction
- Offshore
- Welding of wind tower flanges
- HYPERFILL

## CLASSIFICATION

AWS A5.18 E70C-6M H4  
EN ISO 17632-A T 46 4 M M21 H5

## CURRENT TYPE

DC+

## WELDING POSITIONS

All except vertical down

## SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ 15-25% CO<sub>2</sub>  
Flow rate 15-25 l/min

## APPROVALS

| BV | DNV | RINA | DB |
|----|-----|------|----|
| +  | +   | +    | +  |

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

| Shielding gas | C    | Mn  | Si  | P     | S     |
|---------------|------|-----|-----|-------|-------|
| M21           | 0.04 | 1.5 | 0.4 | 0.012 | 0.020 |

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

|                     | Shielding gas | Condition* | Yield strength (MPa) | Tensile strength (MPa) | Elongation (%) | Impact ISO-V (J)<br>-30°C | Impact ISO-V (J)<br>-40°C |
|---------------------|---------------|------------|----------------------|------------------------|----------------|---------------------------|---------------------------|
| Required: AWS A5.18 |               |            | min. 400             | min. 480               | min. 22        |                           |                           |
| EN ISO 17632-A      |               |            | min. 460             | 530-680                | min. 20        |                           | min. 47                   |
| Typical values      | M21           | AW         | 480                  | 580                    | 27             | 120                       | 110                       |

\* AW = As welded

## PACKAGING AND AVAILABLE SIZES

| Wire diameter (mm) | Packaging    | Weight (kg) | Item number      |
|--------------------|--------------|-------------|------------------|
| 1.2                | SPOOL (B300) | 16.0        | 900401N, 900402N |
|                    | SPOOL (S300) | 16.0        | 900429NE         |
|                    | DRUM         | 200.0       | 900492           |

### 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](http://www.lincolnelectric.eu) for any updated information.