

# Outershield® MC715Ni1-H

## Key Features

- Gas shielded 1% Ni alloyed metal cored wire
- Ni content is controlled to meet “sour service” oil field requirements such as NACE MR0175
- Excellent arc characteristics provide outstanding operator appeal and mechanical properties @ -50°C
- Minimal spatter, fast travel speed, excellent wire feeding
- Superior product consistency with optimal alloy control

## Conformances

**AWS A5.28/A5.28M:** E80C-Ni1M H4

**AS/NZS ISO 17632-A:** T 46 5 1Ni M M 2 H5

**AS/NZS ISO 17632-B:** T 55 5 T15-1 M A N2 U H5

Also complies with

**AS/NZS ISO 17632-B:** T 55 5 T15-1 M A N1 U H5

## Typical Applications

- Welding prequalified procedures for steel group 8C according to AS/NZS 1554.1 Table 4.6.1.
- Mining Equipment
- Oil and Gas industries
- High strength low alloy and quench and tempered (Q&T) steels

## Welding Positions



## Shielding Gas

- 75-85% Argon / 15-25% CO<sub>2</sub>
- 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	941938NE	Spool S300 VFB 16kg	100-550	15-33	120-340	15-20
1.6	941945N	Spool S300 VFB 16kg	150-450	27-34	200-450	15-25

## Mechanical Properties - As required per AWS A5.28

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -45°C	Charpy V-Notch J @ -60°C
Requirements - AWS E80C-Ni1M. As Welded with M21 gas	470 min	550 min	24 min	27 min	-
Typical Results	530	600	25	90	60

## Deposit Composition

	%C	%Mn	%Si	%S	%P	%Ni	Diffusible Hydrogen
Typical Results	0.05	1.35	0.45	0.020	0.020	0.95	3 ml / 100 g