

# Outershield® 71T1

## TOP FEATURES

- Rutile gas shielded flux cored wire designed and qualified for CO<sub>2</sub> shielding gas. Good operator appeal due to welding characteristics slag system
- Stable behavior in root passing on ceramic backing
- CVN > 47J at -20°C
- Suitable for primed plates

## TYPICAL APPLICATIONS

- Shipbuilding
- Steel construction

## CLASSIFICATION

AWS E71T1-C-H8  
 EN ISO T 42 2 P C 2 H10

## CURRENT TYPE

DC+

## WELDING POSITIONS

All except vertical down

## SHIELDING GASES (ACC. EN ISO 14175)

C1 Active gas 100% CO<sub>2</sub>  
 Gas flow 15-25l/min

## APPROVALS

Shielding gas	ABS	DNV	LRS	RINA
C1	+	+	+	+

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

Shielding gas	C	Mn	Si	P	S
C1	0.05	1.1	0.3	0.015	0.010

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -20°C
Required: AWS A5.20			min. 400	490-660	min. 22	min. 27
EN ISO 17632-A			min. 420	500-640	min. 20	min. 47
Typical values	C1	AW	550	580	25	60

\* AW = As welded

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S200)	5.0	900907
	SPOOL (B300)	16.0	900914N

### 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.