

Outershield® MC710RF-H

TOP FEATURES

- Very few silicates, virtually no spatter, fast travel speed, excellent wire feeding.
- Superior on scaled plate, good resistance to porosity.
- Very good mechanical properties (CVN >47) at -30°C).
- Superior product consistency with optimal alloy control.
- Reduced welders' exposure to welding fumes.

TYPICAL APPLICATIONS

- Steel construction
- High quality welds
- Automotive and transportation

CLASSIFICATION

AWS A5.18 E70C-6M H4
EN ISO 17632-A T 46 3 M M21 2 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All except vertical down

SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ 15-25% CO₂
Flow rate 15-25 l/min

APPROVALS

ABS	LR	BV	DNV	RINA	TÜV	DB
+	+	+	+	+	+	+

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

Shielding gas	C	Mn	Si	P	S	HDM
M21	0.05	1.35	0.6	0.015	0.023	3 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)
						-20°C -30°C
Required: AWS A5.18			min. 400	min. 480	min. 22	min. 27
EN ISO 17632-A			min. 460	530-680	min. 20	min. 47
Typical values	M21	AW	495	570	26	90 60

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	901300
	DRUM	200.0	901398

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 for any updated information.