

Outershield® MC715Ni1-H

TOP FEATURES

- Virtually no spatter, high travel speed and excellent wire feeding.
- Excellent mechanical properties (CVN >47J) at -50°C).
- Superior product consistency with optimal alloy control.

TYPICAL APPLICATIONS

- Offshore
- Steel construction

CLASSIFICATION

AWS A5.28	E80C-6M H4
EN ISO 17632-A	T46 5 1Ni M M21 2 H5

CURRENT TYPE

DC+

SHIELDING GASES (ACC. EN ISO 14175)

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

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

Shielding gas	C	Mn	Si	P	S	Ni	HDM
M21	0.05	1.35	0.45	0.020	0.020	0.95	3 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C	-50°C
Required: AWS A5.28			min. 470	min. 550	min. 24	min. 27	
EN ISO 17632-A			min. 460	530-680	min. 20		min. 47
Typical values	M21	AW	530	600	25	100	80

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	941939N
	SPOOL (S300)	16.0	941938N
	DRUM	200.0	941941

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.