Outershield® T55-H

TOP FEATURES

- All position gas shielded basic flux cored wire.
- Good weldability, also vertical up (3G).
- Exceptional mechanical properties (CVN >47J at -50°C).

TYPICAL APPLICATIONS

- Offshore
- Steel construction

CLASSIFICATION

AWS A5.20	E71T-5C-JH4
	E71T-5M-JH4
EN ISO 17632-A	T 42 4 B C1 2 H5
	T 42 4 B M21 2 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All except vertical down

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO_2
C1	Active gas 100% CO_2
Gas flow	15-25l/min

APPROVALS

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

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

Shielding gas	C	Mn	Si	P	S	HDM
C1	0.05	1.5	0.55	0.012	0.010	3 ml/100 g
M21	0.06	1.5	0.6	0.012	0.010	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	-40°C	-50°C
Required: AWS A5.20			min. 400	min. 480	min. 22		min. 27	
EN ISO 17632-A			min. 420	500-640	min. 20		min. 47	
Typical values	M21	AW	480	570	27	130	85	60
		SR: 15h/580°C	425	570	27		80	

* AW = As welded; SR = Stress relieved

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	941609N

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.