Outershield® 555CT-H

TOP FEATURES

- For welding in all positions, except vertical down
- Superior weldability, low spatter, good bead appearance.
- Outstanding operator appeal.
- Exceptional mechanical properties (CVN >47J at -50°C).

TYPICAL APPLICATIONS

- Welding of weather resistant steels
- Steel construction

CLASSIFICATION

AWS A5.29	E81T1-W2M-J
EN ISO 17632-B	T555T1-1MA-NCC1-UH5

CURRENT TYPE

DC+

WELDING POSITIONS

All except vertical down

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	Cr	Cu	HDM
M21	0.03	1.1	0.4	0.015	0.010	0.60	0.55	0.55	4 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:			min. 470	550-690	min. 19	min. 27	
EN ISO 18276-B			min. 460	550-740	min. 17		min. 47
Typical values	M21	AW	600	660	20	140	100

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	942789N

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.