

# Outershield® MC715Ni1-H

## Key Features

- Gas shielded 1% Ni alloyed metal cored wire
- Ni content is controlled to meet "sour service" oil field requirements such as NACE MR0175
- Excellent arc characteristics provide outstanding operator appeal and mechanical properties @ -50°C
- Minimal spatter, fast travel speed, excellent wire feeding
- Superior product consistency with optimal alloy control

## Conformances

**AWS A5.28/A5.28M:** E80C-Ni1M H4

**AS/NZS ISO 17632-B:** T55 5 T15-1 MA N1 UH5

## Typical Applications

- Mining Equipment
- Oil and Gas industries
- High strength low alloy and quench and tempered (Q&T) steels

## Welding Positions



## Shielding Gas

- M21 : 75-85% Argon / 15-25% CO<sub>2</sub>
- Flow Rate: 15-20 L/min

## Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts	Current amps	CTWD mm
1.2	941938/N	Spool S300 VFB 14kg/16kg	100-550	15-33	120-340	15-20
1.2	941941	Accu-Trak Drum 200kg	100-550	15-33	120-340	15-20

## Mechanical Properties - As required per AWS A5.28

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -45°C	Charpy V-Notch J @ -60°C
<b>Requirements</b> - AWS E80C-Ni1M. As Welded with M21 gas	470 min	550	24 min	27 min	-
<b>Typical Results</b>	530	600	25	90	80

## Deposit Composition

	%C	%Mn	%Si	%S	%P	Diffusible Hydrogen
<b>Typical Results</b>	0.05	1.35	0.6	0.023	0.015	3 mls / 100 g