

Toughness Verification Test

This is to state that the product indicated was tested according to the procedures shown. Mechanical properties and chemical analysis of the weld deposit were as shown.

Outershield OS71ELITE

342AR

Diameter (in.): 0.052	Current Type & Polarity: DC+	Volts: 24	Shielding Gas: 100% CO2
Code: 12G23JTUSN	PHT (°F): 300	WFS (ipm): 225	Flow Rate (cfh): 45
Position: 3G-UP	INT (°F): 500	Amps: 210	
Thickness (in.): 0.75		Avg HI (kJ/in): 66.6	
		ESO (in): 0.75	

This product satisfies the requirements of FEMA 353, Appendix D after exposure for 8 weeks at 80°F, 80%RH.

Charpy V-notch Test Results

Temp. (°F)	Energy (ft-lbf)
0	47
	39
	38
70	146
	143
	134

Tensile Test Results

Aging	UTS (ksi)	YP (ksi)	YS (ksi)	EL (%)
48HRS. @ 220F	77.3	71.4	67.8	32

Chemical Test Results

C	S	Mn	Si	P	Al	Ni
0.047	0.008	1.28	0.40	0.011	0.01	0.03

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This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of The Lincoln Electric Company affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.