



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 OSXLH-70

C91R

Diameter (in.): 3/32	Current Type &	Volts: 32	Shielding Gas: 100% CO2
Code: 8I7NY	Polarity: DC+	WFS (ipm): 300	Flow Rate (cfh): 45
Position: 1G	PHT (°F): 500	Amps: 540	
Thickness (in.): 0.75	INT (°F): 500	Avg HI (kJ/in): 84.7	
		ESO (in): 1.125	

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	51
	43
	35
70	92
	92
	91

Tensile Test Results				
Aging	UTS (ksi)	YP (ksi)	YS (ksi)	EL (%)
48HRS@220F	78.2	64.6	60.8	30

Chemical Test Results						
C	S	Mn	Si	P	Al	Ni
0.083	0.012	1.20	0.40	0.010	0.01	0.04

Michael J. Morlock, Certification Supervisor

David A. Fink, Manager, Mature Products Consumable R&D

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.