

Outershield® 555CT-H

CLASSIFICATION

AWS A5.29	E81T1-W2M-J	A-Nr	2
ISO 18276-A	T555T1-1MA-NCC1-UH5	F-Nr	6
		9606 FM	2

GENERAL DESCRIPTION

All position gas shielded 0.6% Ni, 0,5Cr and 0.5% Cu alloyed flux cored wire, for welding weather resistant steel (CorTen)

For welding in all positions

Superior weldability, low spatter, good bead appearance

Outstanding operator appeal

Exceptional mechanical properties (CVN >47J) at -50°C]

Superior product consistency with optimal alloy control

Excellent wire feeding

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

CURRENT TYPE / SHIELDING GAS (ISO 14175)

DC +
M21 : Mixed gas Ar+ (>15-25%) CO₂
Flow rate: 15-25 l/min

CHEMICAL COMPOSITION (W%), 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 (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
						-40°C	-50°C
Required: AWS A5.29			min. 470	550-690	min. 19	min. 27	
EN ISO 17632-B			min. 460	550-740	min. 17	min. 47	
Typical values	M21	AW	600	660	20	140	100

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.2
16 kg spool B300	X

Outershield® 555CT-H: rev. C-EN05-22/06/17

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Standard	Type
Weather Resisting Steel	
EN 10025 part 5	S235 J0W, S235 J2W, S355 J0WP, S355 J2WP, S355 J0W, S355 J2W, S355 K2W
ASTM A242	Type 1
ASTM A588	Grade A, B, C
ASTM A595	All weather resistant steels according A595
ASTM A709	Grade HPS 50W & HPS 70W
ISO 5952	HSA 235W, 245W, 355W1, 355W2, 365W
Weather resistant steels like Cor-Ten®, Patinax®-F, Patinax®-37 and similar Ni- and Cu-alloyed steels	

CALCULATION DATA

Diameter (mm)	Electrical stick-out (mm)	Wire Feed Speed (cm/min)	Current (A)	Arc Voltage (V)	Deposition rate (kg/h)	kg wire/kg weldmetal
1.2	20	445	130	20-22	1.6	1.20
		700	180	23-25	2.5	1.20
		950	220	25-27	3.4	1.20
		1270	265	27-29	4.5	1.20
		1590	305	30-32	5.9	1.20

WELDING PARAMETERS, OPTIMUM FILL PASSES IN SHIELDING GAS Ar + (>15-25)% CO₂

Diameter (mm)	Welding positions				
	PA/1G	PB/2F	PC/2G	PF/3Gup	PE/4G
1.2	230-280A	230-280A	200-240A	200-240A	160-220A
	26-32V	26-32V	25-32V	25-28V	23-28V