

# Outershield® MC420N-H

## TOP FEATURES

- High resistance to porosity
- Designed to withstand normalizing treatment (4h 900°C)
- Mechanical properties after normalizing meet base material requirements

## TYPICAL APPLICATIONS

- Wind tower
- Welding of wind door frames.

## CURRENT TYPE

DC+

## WELDING POSITIONS

All positions

## SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ (>15-25%)  
CO<sub>2</sub>

Flow rate 15-25 l/min

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

Shielding gas	C	Mn	Si	P	S	Cr	Ni	HDM
M21	0.03	0.6	0.45	0.017	0.023	0.03	2.9	3 ml/100 g

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -50°C
Typical values	M21	N = 900°C/4h	353	493	32	57

\* N = Normalising

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.6	SPOOL (S300)	16.0	943327N
	DRUM	200.0	943314
2.0	DRUM	200.0	943316

## 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](http://www.lincolnelectric.eu) for any updated information.