

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

346AR

Diameter (in.): 1/16	Current Type &	Volts: 24	Shielding Gas: 100% CO2
Code: O5A10NU	Polarity: DC+	WFS (ipm): 175	Flow Rate (cfh): 50
Position: 3G-UP	PHT (°F): 300	Amps: 220	
Thickness (in.): 0.75	INT (°F): 500	Avg HI (kJ/in): 65.6	
		ESO (in): 0.75	

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

Temp. (°F)	Energy (ft-lbf)
0	70
	59
	57
70	142
	136
	130

Aging	UTS (ksi)	YP (ksi)	YS (ksi)	EL (%)
48HRS. @ 220F	80.1	74.1	72.5	30

C	S	Mn	Si	P	Al	Ni
0.050	0.006	1.37	0.42	0.015	0.01	0.04

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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.