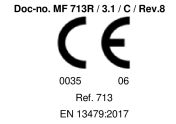




Inspection certificate EN 10204 Type 3.1



Delivery note no.: 80183949

Customer: Meltolit AB
JA Gahms Gata 4
SE-421 32 Västra Frölunda

Customer order no.: 29895

Quantity delivered: 120,00 KG
Customer: (to be filled in by customer)

WZ31/71300E/062691/80183949-20

Quantity delivered: (to be filled in by customer)

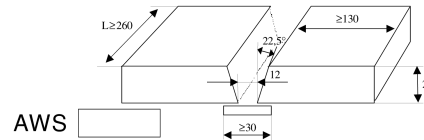
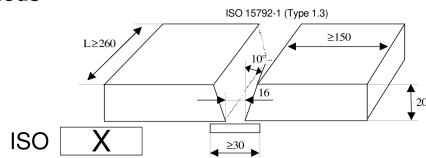
Type: **MEGAFIL 713 R**
Diameter Ø: **1.0 mm | 0.039"**
Batch: **062691**

Specification: T 46 2 P C 1 1 H5
ISO 17632 A: E71T-1C-J H4
AWS ASME 5.20:

Current: =+/DCEP 220 A
Voltage: 27 V
Welding speed: 20-25 cm/min
Shielding gas / Flux: CO2
Flow rate: 15 l/min
Stick out: 20-15 mm
Position: PA (1G)
Interpass temp.: 150 °C 302 °F

DB-type certificate: 42.027.03
TÜV-type certificate: 07602
Lot classification: T4
Testing schedule: 1

Test methods



ISO 6847 All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,05	0,28	1,23	0,009	0,006	0,026	0,018	0,001	0,136	0,002	0,019	0,033	0,010	0,006
ISO													
		max.			max.	max.	max.	max.		max.		max.	
		2,00			0,20	0,50	0,20	0,30		0,08		0,05	
AWS													
max.	max.	max.	max.	max.									
0,12	0,90	1,75	0,03	0,03									

Mechanical properties of the pure weld metal

Heat-treatment	Tensile test ISO 5178			Impact test ISO 9016 VWT 0/b									
	Rm [MPa]	Rp0,2 [%]	A [%]	RT	0°C	-20°C	-40°C	-60°C	RT	32°F	-4°F	-40°F	-76°F
as welded	537	471	22			131					96		
	min. 530	min. 460	min. 20			134					99		
	[ksi]	[%]	[%]			122					90		
	78	68	22			129					95		
	min. 77	min. 67	min. 20										

Name: Jutzi
Date: 18.08.2022

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