



Inspection certificate EN 10204 Type 3.1



Delivery note no.: 80218772

Customer: Meltolit AB
JA Gahms Gata 4
SE-421 31 Västra Frölunda

Customer order no.: 31073

Quantity delivered: 976,00 KG
Customer: (to be filled in by customer)

Certificate no.: WZ31/71015E/014605/80218772-70

Quantity delivered: (to be filled in by customer)

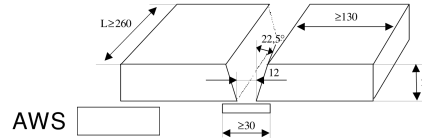
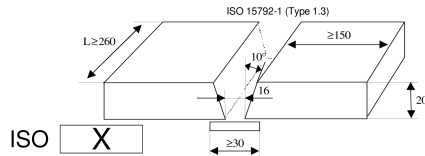
Type: **MEGAFIL 710 M**
Diameter Ø: **1.2 mm | 0.045"**
Batch: **014605**

Specification: T 46 6 M M21 1 H5
ISO 17632 A: E70C-6M H4
AWS A5.18:

Current: **±/DCEP** 240 A
Voltage: 27 V
Welding speed: 35-40 cm/min
Shielding gas / Flux: M21(82/18)
Flow rate: 15 l/min
Stick out: 15-20 mm
Position: PA (1G)
Interpass temp.: 150 °C 302 °F

DB-type certificate: 42.027.05
TÜV-type certificate: 07605

Test methods



All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,06	0,74	1,44	0,006	0,004	0,031	0,019	0,001	0,098	0,004	0,004	0,016	0,000	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.	max.	max.	max.	max.		max.			
0,12	0,90	1,75	0,03	0,03	0,20	0,50	0,30	0,50		0,08			

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	637	573	28					128					94
	min. 530	min. 460	min. 20					118					87
	[ksi]		[%]					140					103
	92	83	28					129					95
	min. 77	min. 67	min. 20										

Name: Jutzi
Date: 21.02.2024

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