



Inspection certificate
EN 10204 Type 3.1

Doc-no. MF 710M / 3.1 / M / Rev.B



Delivery note no.: 80240002

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

Customer order no.: 32137

Quantity delivered: 60,00 KG
Customer: (to be filled in by customer)

Certificate no.: WZ317/71012E/034635/80240002-40

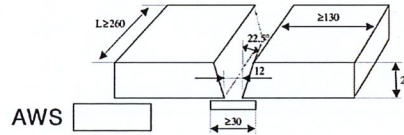
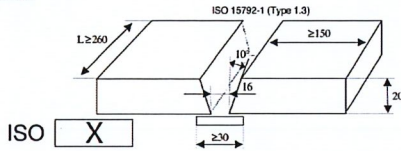
Quantity delivered: (to be filled in by customer)

Type: **MEGAFIL 710 M**
Diameter Ø: **1.2 mm | 0.045"**
Batch: **034635**
Specification: **T 46 6 M M21 1 H5**
ISO 17632 A: **E70C-6M H4**
AWS A5.18:

Current: =+/DCEP 250 A
Voltage: 27,5 V
Welding speed: 35 cm/min
Shielding gas / Flux: M21(82/18)
Flow rate: 15 l/min
Stick out: 20-15 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 |
|------|------|------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 0,04 | 0,65 | 1,57 | 0,008 | 0,005 | 0,020 | 0,017 | 0,002 | 0,126 | 0,003 | 0,004 | 0,014 | 0,000 | 0,007 |
| 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 [MPa] | A [%] | RT | 0°C | -20°C | -40°C | -60°C | RT | 32°F | -4°F | -40°F | -76°F |
| as welded | 635 | 577 | 27 | | | | | 156 | | | | | 115 |
| | min. 530 | min. 460 | min. 20 | | | | | 149 | | | | | 110 |
| | | | | | | | | 174 | | | | | 128 |
| | 92 | 84 | 27 | | | | | 160 | | | | | 118 |
| | min. 77 | min. 67 | min. 20 | | | | | | | | | | |

Name: Kaufhold
Date: 07.05.2024

This document was generated electronically and is valid without signature.