



Inspection certificate EN 10204 Type 3.1

Doc-no. MF 742M / 3.1 / M / Rev.8



Delivery note no.: 80214273

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

Customer order no.: 30991

Quantity delivered: 1 024,00 KG
Customer: (to be filled in by customer)

Certificate no.: WZ31/74215E/043644/80214273-10

Quantity delivered: (to be filled in by customer)

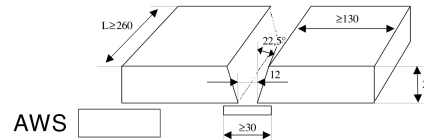
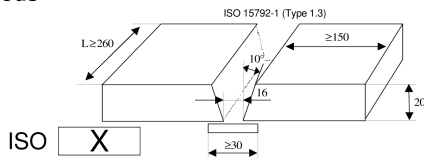
Type: **MEGAFIL 742 M**
Diameter Ø: **1.2 mm | 0.045"**
Batch: **043644**

Specification: T 69 6 Mn2NiCrMo M M21 1 H5
ISO 18276 A: E110C-K4 H4
AWS ASME 5.28:

Current: =+/DCEP 240 A
Voltage: 27,5 V
Welding speed: 40-43 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

Peculiarity: WIWEB approved
TÜV-type certificate: 09538

Test methods



All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,05	0,44	1,48	0,008	0,006	0,306	2,298	0,3	0,120	0,004	0,007	0,045	0,000	0,041
ISO													
0,03 - 0,10	max. 0,90	1,4 - 2,0	max. 0,02	max. 0,02	0,3 - 0,6	1,8 - 2,6	0,3 - 0,6	max. 0,30		max. 0,05		max. 0,05	
AWS													
max. 0,15	max. 0,80	1,20 - 2,25	max. 0,03	max. 0,03	0,20 - 0,65	1,75 - 2,60	0,20 - 0,65	max. 0,35		max. 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 [MPa]	A [%]	RT	0°C	-20°C	-40°C	-60°C	RT	32°F	-4°F	-40°F	-76°F
as welded	853	828	18				119	123				88	91
	min. 770	min. 690	min. 17				131	107				96	79
	[ksi]		[%]				115	70				85	52
	124	120	18				122	100				90	74
	min. 112	min. 100	min. 17										

Name: Jutzi
Date: 11.05.2023

This document was generated electronically and is valid without signature.