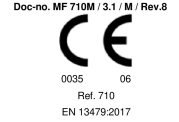




**Inspection certificate
EN 10204 Type 3.1**



Delivery note no.: 80140382
Customer order no.: 660510

Customer: Österbergs Industrihandel AB
Brisgatan 1
SE-65221 Karlstad

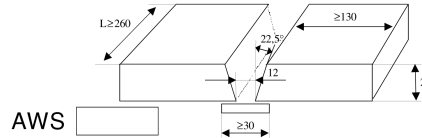
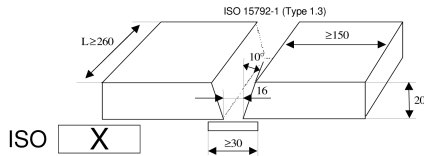
Quantity delivered: 64,00 KG
Customer:
(to be filled in by customer)

Quantity delivered:
(to be filled in by customer)

Type: MEGAFIL 710 M
Diameter Ø: 1.2 mm | 0.045"
Batch: 051671
Specification:
ISO 17632 A: T 46 6 M M21 1 H5
AWS ASME 5.18: E70C-6M H4
AWS ASME 5.36: E81T15-M21A8-CS1-H4
DB-type certificate: 42.027.05
TÜV-type certificate: 07605
Lot classification: T4
Testing schedule: 1

Current: =+/DCEP 250 A
Voltage: 27,4 V
Welding speed: 35-40 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

Test methods



ISO 6847 All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,06	0,84	1,50	0,010	0,006	0,020	0,023	0,005	0,106	0,010	0,006	0,014	0,008	0,009
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	639	586	26					120					88
	min. 530	min. 460	min. 20					129					95
								132					97
	93	85	26					127					94
	min. 77	min. 67	min. 20										

Name: Jutzi
Date: 02.06.2021

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