



Inspection certificate EN 10204 Type 3.1

Doc-no. MF 710M / 3.1 / M / Rev.8



Delivery note no.: 80140382

Customer: Österbergs Industrihandel AB
Brisgatan 1
SE-65221 Karlstad

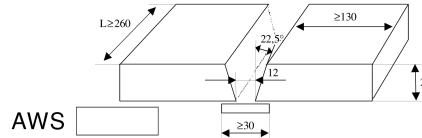
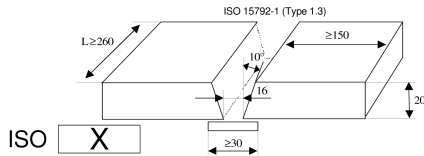
Customer order no.: 660510

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

Type: **MEGAFIL 710 M**
Diameter Ø: **1.0 mm | 0.039"**
Batch: **061692**
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 225 A
Voltage: 26,9 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

Test methods



ISO 6847 All weld metal chemical composition (%)

| C | Si | Mn | P | S | Cr | Ni | Mo | Cu | Al | V | Ti | Nb | N2 |
|------|------|------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 0,04 | 0,70 | 1,64 | 0,007 | 0,010 | 0,031 | 0,032 | 0,005 | 0,113 | 0,012 | 0,007 | 0,021 | 0,008 | 0,005 |
| 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 | 646 | 595 | 25 | | | | | 141 | | | | | 104 |
| | min. 530 | min. 460 | min. 20 | | | | | 162 | | | | | 119 |
| | [ksi] | 86 | 25 | | | | | 155 | | | | | 114 |
| | min. 77 | min. 67 | min. 20 | | | | | 153 | | | | | 112 |

Name: Jutzi
Date: 21.07.2021

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