



Inspection certificate EN 10204 Type 3.1

Doc-no. MF 713R / 3.1 / C / Rev.8

Delivery note no.: 80241973

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

Customer order no.: 32234

Quantity delivered: 3 072,00 KG
Customer: (to be filled in by customer)

Certificate no.: WZ31/71315E/074703/80241973-40

Quantity delivered: (to be filled in by customer)

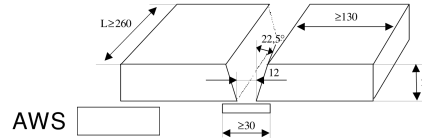
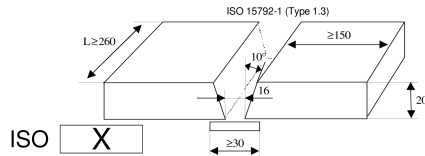
Type: **MEGAFIL 713 R**
Diameter Ø: **1.2 mm | 0.045"**
Batch: **074703**

Specification:
ISO 17632 A: T 46 2 P C1 1 H5
ASME SFA 5.20 / AWS A5.20: E71T-1C-J H4

Current: =+/DCEP 240 A
Voltage: 26,5 V
Welding speed: 35 cm/min
Shielding gas / Flux: CO2
Flow rate: 15 l/min
Stick out: 20-15 mm
Position: PA (1G)
Interpass temp.: 150 °C 302 °F

The scope of approval can be found on the product labels.

Test methods



All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,03	0,34	1,15	0,010	0,004	0,029	0,009	0,001	0,130	0,001	0,017	0,026	0,008	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.									
0,12	0,90	1,75	0,03	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 [%]	A [%]	RT	0°C	-20°C [J]	-40°C	-60°C	RT	32°F	-4°F [ft-lbf]	-40°F	-76°F
as welded	561	517	27			72					53		
	min. 530	min. 460	min. 20			66					49		
	[ksi]	[%]	[%]			54					40		
	81	75	27			64					47		
	min. 77	min. 67	min. 20										

Name: Jutzi
Date: 14.08.2024

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