



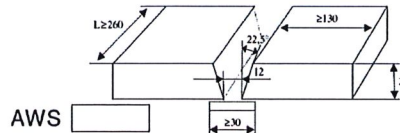
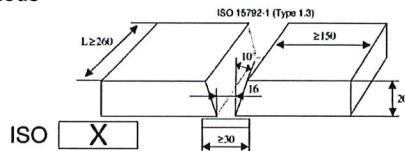
Inspection certificate  
EN 10204 Type 3.1

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



Delivery note no.:	80101940	Customer:	Mellotit AB JA Gahms Gala 4 SE-421 32 Västra Frölunda
Customer order no.:	27600	Quantity delivered:	3 072,00 KG
Type:	<b>MEGAFIL 710 M</b>	Customer:	(to be filled in by customer)
Diameter Ø:	<b>1.2 mm   0.045"</b>	Quantity delivered:	(to be filled in by customer)
Batch:	<b>100762</b>	Current: =+/DCEP	250 A
Specification:	T 46 6 M M21 1 H5	Voltage:	28,9 V
ISO 17632 A:	E70C-6M H4	Welding speed:	35-40 cm/min
AWS ASME 5.18:	E81T15-M21A8-CS1-H4	Shielding gas / Flux:	M21(82/18)
AWS ASME 5.36:	42.027.05	Flow rate:	15 l/min
DB-type certificate:	07605	Stick out:	20-15 mm
TÜV-type certificate:	T4	Position:	PA (1G)
Lot classification:	1	Interpass temp.:	150 °C 302 °F
Testing schedule:			

Test methods



ISO 6847 All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,05	0,58	1,39	0,004	0,017	0,022	0,054	0,016	0,138	0,015	0,001	0,018	0,001	0,008
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	618	557	27				154	102				113	75
	min. 530	min. 460	min. 20				153	92				113	68
	[ksi]		[%]				120	89				88	66
	90	81	27				142	94				105	69
	min. 77	min. 67	min. 20										

Name: Gümüs  
Date: 11.12.2020

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