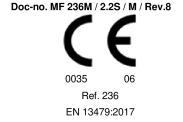




**Inspection certificate
EN 10204 Type 3.1 / 2.2**



Delivery note no.: 80186378

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

Customer order no.: 29923

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

Certificate no.: WZ22S/23615E/033630/80186378-10

Quantity delivered: (to be filled in by customer)

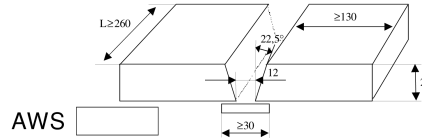
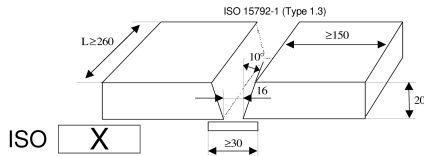
Type: **MEGAFIL 236 M**
Diameter Ø: **1.2 mm | 0.045"**
Batch: **033630**

Specification: T CrMo1 M M21 1 H5
ISO 17634 A: E80C-B2 H4
AWS ASME 5.28:

Current: =+/DCEP 230 A
Voltage: 27,5 V
Welding speed: 20-25 cm/min
Shielding gas / Flux: M21(82/18)
Flow rate: 15 l/min
Stick out: 15-20 mm
Position: PA (1G)
Interpass temp.: 200 °C 392 °F

DB-type certificate: 11059
TÜV-type certificate:

Test methods



EN 10204 - 3.1: All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,05	0,31	0,87	0,008	0,005	1,148	0,019	0,401	0,082	0,005	0,008	0,008	0,002	0,009
ISO													
	max.		max.	max.		max.		max.		max.		max.	
0,05 - 0,12	0,80	0,40 - 1,30	0,02	0,02	0,90 - 1,40	0,30	0,40 - 0,65	0,30		0,03		0,10	
AWS													
			max.	max.		max.				max.			
0,05 - 0,12	0,25 - 0,60	0,40 - 1,00	0,03	0,03	1,00 - 1,50	0,20	0,40 - 0,65			0,03			

EN 10204 - 2.2: Mechanical properties of the pure weld metal (typical values)

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
690°C / 1h	600	520	24										
	min. 510	min. 355	min. 20										
1274°F / 1h	87	75	24	120			52		88			38	
	min. 74	min. 52	min. 20										

Name: Jutzi
Date: 03.04.2023

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