

Product Type: TM-770
 Classification: E71T-1M, E71T-12MJH8
 Specifications: AWSA5.20-95; ASMESFA5.20
 Diameter Tested: 1/16"
 Date Tested: 6/16/08
 Date Generated: 6/17/2008

This is to certify that the product named above and supplied on the referenced order number is of the same classification, manufacturing process, and material requirements as the material which was used for the test that was concluded on the dates shown, the results of which are shown below. All tests required by the specifications shown for classification were performed at that time and the material tested met all requirements. It was manufactured and supplied by the Quality System Program of Hobart Brothers, which meets the requirements of ISO 9000, ANSI/AWSA 5.01, and other specification and Military requirements, as applicable.

Test Settings

Shielding Medium	Amps/Polarity	Volts	WFS in/min(m/min)	ESOI in(mm)	Preheat F(C)	Interpass F(C)	Travel Speed in/min(cm/min)
SG-AC-20	275/DCEP	25	232(5.9)	.75(19)	70(21)	300(149)	10(25.4)

Mechanical Properties-Tensile

Shielding Medium	Ref.No.	Testing Conditions	Ult. Tensile Strength psi (MPa)	Yield Strength psi(MPa)	Elong. %in2"
SG-AC-20	PA7147	As Welded	83,000(572)	76,000(524)	28

Mechanical Properties-Impact

Shielding Medium	Ref.No.	Testing Conditions	Temp. F(C)	Individuals ft.lb.(J)	Avg. ft.lb.(J)	Type
SG-AC-20	PA7147	As Welded	0(-18)	114,123,132(155,167,179)	123(167)	Charpy-V-Notch
SG-AC-20	PA7147	As Welded	-40(-40)	64,80,82(87,108,111)	75(102)	Charpy-V-Notch

Ref.No.	Radiographic Inspection	Fillet Weld Test			
PA7147	Conforms	Horizontal:	Overhead:	Conforms	Vertical: Conforms

Chemical Analysis

Shielding Medium/Ref.No	C	Mn	P	S	Si	Cu	Cr	V	Ni	Mo	Al	Ti	Nb	Co	B	W	Sn	Fe	Sb	N	Mg	Zn	Be
SG-AC-20/CA69831	0.03	1.25	0.013	0.006	0.35	0.02	0.05	0.02	0.32	0.01	*	*	*	*	*	*	*	*	*	*	*	*	*

Diffusible Hydrogen Collected per AWSA 4.3

SG-AC-20	3.0ml/100g of weld metal for 1/16 inch diameter
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Joe O'Leary, Manager, Quality Assurance



Melvin Seitz, Quality Manager

Certification and Limited Warranty-Data for the above supplied product are those obtained when welded and tested in accordance with the above specification. All tests for the above classification were satisfied. Other tests and procedures may produce different results. Hobart Brothers produces welding consumables under continuing quality assurance programs audited and approved by the American Bureau of Shipping ("ABS").