



Product: FabCOR Edge MC
Diameter: .045"
Shielding Gas: SG-AC 10
Current/Polarity: DCEP
Classification: E70C-6M H4
Specification: AWS A5.18/A5.18M:2005
Test Completed: 1/20/17

Certificate of Conformance

For AWS D1.8/D1.8M, Seismic Supplement

This is to certify that the product named is of the same classification, manufacturing process, and material requirements as the material, which was used for the test which was concluded on the date shown, the results of which are shown below. All test required by the code or specifications were performed at that time and the material tested met all requirements. The product was manufactured and supplied by the Quality System Program of Hobart Brothers, which meets the requirements of ISO9001:2008, ANSI/AWS A5.01, and other specification and Military requirements, as applicable.

Test Settings	High Heat Input	Low Heat Input	Lot- # Z615510614402	AWS D1.8 Requirements	High Heat Input	Low Heat Input	
	79.8 kJ/in	28.8 kJ/in	Mechanical Properties		79.8 kJ/in	28.8 kJ/in	
			Test Reference #		PD2884	PD2883	
Voltage	28.5	28.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000	72,900	84,400	
Current (amps)	280	280			58,000	58,900	73,300
WFS (ipm)	390	407			22	32	26
Travel Speed (ipm)	6	16.6			40	127	86
Stick Out	3/4"	3/4"					
# of passes	9	16					
# of layers	4	6					
Preheat Temp. °F	300+/-25	RT					
Interpass Temp. °F	500+/-50	200+/-25					
Weld Position	1G	1G					

Test Settings	High Heat Input	Low Heat Input	Lot- # Z625400610402	AWS D1.8 Requirements	High Heat Input	Low Heat Input	
	96.0 kJ/in	29.6 kJ/in	Mechanical Properties		96.0 kJ/in	29.6 kJ/in	
			Test Reference #		PD2881	PD2880	
Voltage	28.5	28.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000	75,300	85,200	
Current (amps)	300	280			58,000	60,100	74,900
WFS (ipm)	480	407			22	34	27
Travel Speed (ipm)	6	16.2			40	95	84
Stick Out	3/4"	3/4"					
# of passes	6	16					
# of layers	4	6					
Preheat Temp. °F	300+/-25	RT					
Interpass Temp. °F	500+/-50	200+/-25					
Weld Position	1G	1G					

Test Settings	High Heat Input	Low Heat Input	Lot- # Z622031024172	AWS D1.8 Requirements	High Heat Input	Low Heat Input	
	79.8 kJ/in	29.7 kJ/in	Mechanical Properties		79.8 kJ/in	29.7 kJ/in	
			Test Reference #		PD2879	PD2878	
Voltage	28.5	28.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000	73,600	84,800	
Current (amps)	280	280			58,000	58,600	72,800
WFS (ipm)	390	407			22	32	28
Travel Speed (ipm)	6	16.1			40	94	61
Stick Out	3/4"	3/4"					
# of passes	9	16					
# of layers	4	6					
Preheat Temp. °F	300+/-25	RT					
Interpass Temp. °F	500+/-50	200+/-25					
Weld Position	1G	1G					

Diffusible Hydrogen - Tested in accordance with AWS A5.18/A5.18M, Clause 15 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	Z622031024172	HB1296	1.5 (ml/100g)
7 Day Exposure	Z622031024172	HB1313	1.8 (ml/100g)

The information contained or otherwise referenced herein is presented without guarantee or warranty. Hobart Brothers Company ("Hobart") expressly disclaims any liability incurred from any reliance thereon. Data for the above-supplied product are those obtained during the welding process and tested in accordance with the above specification with electrodes of the same manufacturing processes and material requirements. All tests for the above classification were performed satisfactorily. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart. **Hobart produces welding consumables under continuing quality assurance programs audited and approved by the American Bureau of Shipping ("ABS").** Please refer to the Hobart Brothers Company website at www.hobartbrothers.com for current Safety Data Sheets ("SDS").

David A. Thomas, Quality Assurance Representative