



Product: Fabshield XLNT-6
Diameter: 3/32"
Shielding Gas: N/A
Current/Polarity: DCEP
Classification: AWS E70T-6
Specification: AWS A5.20/A5.20M:2021
Test Completed: 6/21/2022

Certificate of Conformance

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

This is to certify that the product named herein is of the same classification, manufacturing process, and material requirements as the material used for the tests completed on the date shown, the results of which are recorded below. All tests 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 Management System of Hobart Brothers, which meets the requirements of ISO 9001:2015, ANSI/AWS A5.01, and other specification and Military requirements, as applicable.

Test Settings	High Heat Input	Low Heat Input	Lot- # F05735	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	69.8 kJ/in	40.0 kJ/in	Mechanical Properties		69.8 kJ/in	40.0 kJ/in
			Test Reference #		PE4114	PE4265
Voltage	25	21.8	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	76,000 59,000 27 46	91,000 75,000 22 40
Current (amps)	475	335				
WFS (ipm)	300	135				
Travel Speed (ipm)	10.2	10.7				
Stick Out	1.25"	1"				
# of passes	7	13				
# 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- # C001421501313	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	73.5 kJ/in	42.8 kJ/in	Mechanical Properties		73.5 kJ/in	42.8 kJ/in
			Test Reference #		PD7586	PD7473
Voltage	26	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	77,000 58,000 28 51	93,000 77,000 22 42
Current (amps)	445	310				
WFS (ipm)	260	125				
Travel Speed (ipm)	9.4	10.87				
Stick Out	1"	1"				
# of passes	6	13				
# 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- # Z006572402502	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	70.8 kJ/in	41.3 kJ/in	Mechanical Properties		70.8 kJ/in	41.3 kJ/in
			Test Reference #		PD0962	PD1068
Voltage	26	22	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	80,000 59,000 24 47	94,000 75,000 24 45
Current (amps)	443	322				
WFS (ipm)	260	140				
Travel Speed (ipm)	9.75	11.68				
Stick Out	1"	1"				
# of passes	7	12				
# of layers	4	5				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Diffusible Hydrogen - Tested in accordance with AWS A5.20/A5.20M, Clause 16 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	F05735	HB5550	7.1 (ml/100g)
7 Day Exposure	F05735	HB5585	7.8 (ml/100g)

The information contained or otherwise referenced herein is presented without guarantee or warranty. Hobart Brothers LLC 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 Brothers. Please refer to the Hobart Brothers website at www.hobartbrothers.com for current Safety Data Sheets.

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