



Certificate of Conformance to Requirements for Welding Electrode

Customer:	Product Type:	HB 28 .045 45 SP
Customer P.O. No.:	Classification:	ER70S-6
Order No.:	Specifications:	A5.18 /SFA 5.18, F-6, A-1
Stock Number: S305412-045	Diameter Tested:	.045"
Lbs. Shipped:	Date Tested:	12/04/2020
Date Generated: 3/19/2021	Diameter Shipped:	.045 in
Lot Nos. Shipped:		

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 date 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 9001, ANSI/AWS A5.01, and other specification and Military requirements, as applicable. This document supplies actual test results of non-specific inspection in conformance with the requirements of EN 10204, type 2.2 certification.

Test Settings

Shielding Medium	Amps / Polarity	Volts	WFS in/min(m/min)	ESO in(mm)	Preheat F(C)	Interpass F(C)	Travel Speed in/min(cm/min)
C1 (100% CO2)	275 / DCEP	27	240 (6.1)	3/4 (19)	Room Temp	300(149)	10 (25.4)

Mechanical Properties - Tensile

Shielding Medium	Ref. No.	Testing Conditions	Ult. Tensile Strength psi (MPa)	Yield Strength psi (MPa)	Elong.% in 2"
C1 (100% CO2)	PE1670	As Welded	81,000 (560)	66,000 (458)	28

Mechanical Properties - Impact

Shielding Medium	Ref. No.	Testing Conditions	Temp. F (C)	Individuals ft.lb.(J)	Avg. ft.lb.(J)	Type
C1 (100% CO2)	PE1670	As Welded	-20 (-29)	66,69,73 (89,94,99)	69 (94)	Charpy-V-Notch

Ref.No.	Radiographic Inspection	Fillet Weld Test		
		Horizontal :	Overhead :	Vertical :
PE1670	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	Sb	As
None / CD69526	0.08	1.48	0.012	0.010	0.87	0.1	0.03	0.00	0.01	0.00															

Dave Thomas, Quality Assurance Rep.

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.