



Product: Corex Flux-Cor 7
Diameter: 1/16"
Shielding Gas: SG-C
Current/Polarity: DCEP
Classification: E70T-1, E70T-9
Specification: AWS A5.20/A5.20M:2005
Test Completed: 8/15/16

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 ISO 9001:2008, ANSI/AWS A5.01, and other specification and Military requirements, as applicable.

Test Settings	High Heat Input	Low Heat Input	Lot- # Z020301601432	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.5 kJ/in	29.4 kJ/in			81.5 kJ/in	29.4 kJ/in
			Mechanical Properties			
			Test Reference #		PD1897	PD1961
Voltage	32	28	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft·lbs @ +70 °F	70,000 58,000 22 40	86,800 71,900 29 79	100,000 92,400 23 65
Current (amps)	400	250				
WFS (ipm)	400	210				
Travel Speed (ipm)	9.4	14.3				
Stick Out	3/4"	3/4"				
# of passes	7	23				
# of layers	4	8				
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- # V018271208323	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.3 kJ/in	29.6 kJ/in			81.3 kJ/in	29.6 kJ/in
			Mechanical Properties			
			Test Reference #		PC0789	PC0802
Voltage	32	28	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft·lbs @ +70 °F	70,000 58,000 22 40	87,300 71,200 28 63	102,000 94,600 23 54
Current (amps)	398	259				
WFS (ipm)	400	208				
Travel Speed (ipm)	9.4	14.7				
Stick Out	3/4"	3/4"				
# of passes	7	21				
# of layers	4	7				
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- # P010841906092	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.1 kJ/in	40.2 kJ/in			80.0 kJ/in	30.0 kJ/in
			Mechanical Properties			
			Test Reference #		PB1644	PB1671
Voltage	34	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft·lbs @ +70 °F	70,000 58,000 22 40	82,200 69,000 28 78	97,700 87,900 24 63
Current (amps)	550	350				
WFS (ipm)	225	125				
Travel Speed (ipm)	14	14.1				
Stick Out	1"	1"				
# of passes	9	14				
# 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	Z020301601432	HB0827	7.9 (ml/100g)
7 Day Exposure	Z020301601432	HB0821	4.4 (ml/100g)

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David A. Thomas, Quality Assurance Representative



Product: Corex Flux Cor 7
Diameter: 3/32"
Shielding Gas: SG-C
Current/Polarity: DCEP
Classification: E70T-1, E70T-9C
Specification: AWS A5.20/A5.20M:2005
Test Completed: 2/12/16

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 ISO 9001:2008, ANSI/AWS A5.01, and other specification and Military requirements, as applicable.

Test Settings	High Heat Input	Low Heat Input	Lot- # Z002191114072	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.1 kJ/in	37.8 kJ/in	Mechanical Properties		80.1 kJ/in	37.8 kJ/in
			Test Reference #		PD0546	PD0535
Voltage	34	27	Tensile Strength (psi)	70,000	89,700	99,400
Current (amps)	550	350	Yield Strength (psi)	58,000	73,500	91,900
WFS (ipm)	225	125	Elongation (%)	22	26	23
Travel Speed (ipm)	14	15	Average Charpy V-notch			
Stick Out	1"	1"	Impact Properties ft•lbs @	40	70	61
# of passes	8	14	+70 °F			
# 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- # T047781112061	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.4 kJ/in	37.3 kJ/in	Mechanical Properties		79.4 kJ/in	37.3 kJ/in
			Test Reference #		PB9039	PB9202
Voltage	34	27	Tensile Strength (psi)	70,000	90,100	102,500
Current (amps)	549	350	Yield Strength (psi)	58,000	74,900	93,900
WFS (ipm)	225	125	Elongation (%)	22	26	23
Travel Speed (ipm)	14.1	15.2	Average Charpy V-notch			
Stick Out	1"	1"	Impact Properties ft•lbs @	40	67	54
# of passes	8	14	+70 °F			
# 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- # P007361110073	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.1 kJ/in	40.2 kJ/in	Mechanical Properties		80.1 kJ/in	40.2 kJ/in
			Test Reference #		PB1626	PB1638
Voltage	34	27	Tensile Strength (psi)	70,000	92,300	100,300
Current (amps)	550	350	Yield Strength (psi)	58,000	79,800	93,700
WFS (ipm)	225	125	Elongation (%)	22	26	23
Travel Speed (ipm)	14	14.1	Average Charpy V-notch			
Stick Out	1"	1"	Impact Properties ft•lbs @	40	57	58
# of passes	9	14	+70 °F			
# 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	Z002191114072	HB0243	5.9 (ml/100g)
7 Day Exposure	Z002191114072	HB0279	5.7 (ml/100g)

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