

Delivery note no.: 80139992

Customer: Hobart Brothers LLC
1260 Bruckner Drive
Troy, OH 45373

Customer order no.: 119834 / Jon Mitchel

Quantity delivered: 15,360.00 KG
Customer: (to be filled in by customer)

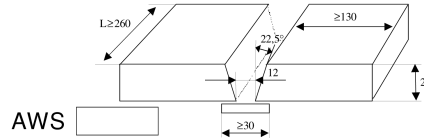
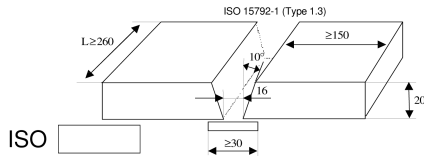
Type: **Elgacore Matrix**
Diameter Ø: **1.6 mm | 1/16"**
Batch: **022628**

Specification: T 46 4 M M21 3 H5
ISO 17632 A: E70C-6M H4
AWS ASME 5.18:

Current: =+/DCEP 300 A
Voltage: 29 V
Welding speed: 35 cm/min
Shielding gas / Flux: M21(82/18)
Flow rate: 15 l/min
Stick out: 20 mm
Position: PA (1G)
Interpass temp.: °C 0 °F

DB-type certificate: 42.027.23
TÜV-type certificate: 19810
Lot classification: T4
Testing schedule: 1

Test methods



EN 10204 - 3.1: ISO 6847 All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,04	0,47	1,24	0,008	0,007	0,022	0,014	0,007	0,014	0,012	0,012	0,032	0,000	0,005
ISO													
		max.			max.		max.						
		2,00			0,20		0,20						
AWS													
max.	max.	max.	max.	max.	max.	max.	max.	max.		max.			
0,12	0,90	1,75	0,03	0,03	0,20	0,50	0,30	0,50		0,08			

EN 10204 - 2.2: Mechanical properties of the pure weld metal (typical values)

Heat-treatment	Tensile test ISO 5178			Impact test ISO 9016 VWT 0/b									
	Rm [MPa]	Rp0,2 [%]	A [%]	RT	0°C	-20°C	-40°C	-60°C	RT	32°F	-4°F	-40°F	-76°F
as welded	575	515	25										
	min. 530	min. 460	min. 20										
	83	75	25			100	60				74	44	
	min. 77	min. 67	min. 20										

Name: Jutzi
Date: 11.03.2022

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