



**Certificate of Conformance
to Requirements for Welding Electrode
EN 10204 3.1**

Customer :		
Product : HA-495	Customer P.O.# : 2000-000631	Certificate No. : F031722-2
Lot No. : 220103	Mesh Size :	Date of Mfg. : 01/03/2022
Specification : --	Classification :-	Date of Issue : 03/31/2022

CHEMICAL ANALYSIS OF FLUX FOR SUBMERGED ARC WELDING

SiO ₂	5.1%
Al ₂ O ₃ + TiO ₂	59.8%
MnO + FeO	16.3%
CaO + MgO + CaF ₂	18.5%



J. M. Wang

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Manufacturing, Certification and Limited Warranty Agreement

Data for the above supplied product are those obtained when welded and tested accordance with the above specification. All tests for the above classification were satisfied. Other tests and procedures may produce different results. The above supplied product are manufactured by Tien Tai Electrode an ITW Co. located at: No.6 Kaifa 4th Rd., Rende Dist., Tainan City 717, Taiwan R.O.C. Hobart Brothers produces welding consumables under continuing quality assurance programs audited and approved by Lloyd's Register Quality Assurance Limited(LRQA)



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Customer :

Product : HOBART M12K/HA-495

Customer P.O.# : 2000-000631

Part Number :

Diameter : 4.0mm

Lot No. : 210621116S40/220103

Lot Classification :

Classification : F7A0-EM12K

Date Tested : 01/11/2022

Level of Testing :

Specification : AWS A5.17-'19

Date of Issue : 03/31/2022

Test Settings

Amps DCEP	Volts	WFS	Shielding Gas	Electrode Stickout	Temperature		Travel Speed
					Preheat	Interpass	
500	28	43 ipm	NONE	35 mm	85±25°F	300±25°F	16±1 ipm
					30±15°C	150±15°C	

6 Layers, 2 passes on each layer 1 through 6; 7th Layer, 3 passes on cap layer; Direction reversed on each layer.

Mechanical Properties Lab Test #2BA11

Shielding Gas	Testing Conditions	Ult. Tensile Strength	Yield Strength	Elong % in 2"	Impact Test Temp.	Charpy V-Notch Values ft.lbf		
NONE	AS WELDED	90316 psi	78511 psi	30	-4 °F	65	65	66
		623 MPa	541 MPa		-20 °C	Average 65	(88 J)	

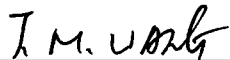
Radiographic		Fillet Weld Test						Moisture %
Inspection:	Conforms	Horizontal:	N/A	Vertical:	N/A	Overhead:	N/A	N/A
Bending Test								

Chemical Composition of Wire and Rod (%)

Elements	C	Mn	Si	S	P	Cu								
Filler Metal	0.09	1.06	0.27	0.003	0.014	0.010								

Remarks

Production Date :01/03/2022


 Q.C Section: J.M. Wang

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