



**Inspection Certificate
In accordance with
EN 10204 3.1**

Customer :		
Product : HF-N	Customer P.O.# : 2000-012208/PO:ICO-02122554	Certificate No. : F092225-2
Lot No. : 250909	Mesh Size :	Date of Mfg. : 09/09/2025
Specification : --	Classification : --	Date of Issue : 09/22/2025

CHEMICAL ANALYSIS OF FLUX FOR SUBMERGED ARC WELDING

SiO ₂	11.2%
Al ₂ O ₃ + TiO ₂	17.2%
MnO + FeO	0.4%
CaO + MgO + CaF ₂	70.9%



J. M. Wang
Q.C Section J. M. WANG

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)



Certificate No. :B092225-2

**Inspection Certificate
In accordance with
EN 10204 3.1**

Customer :

Product : METALLOY 865-S MOD/HF-N
Diameter : 3.2mm
Classification : --
Specification : --

Customer P.O.# : 2000-012208/PO:ICO-02122554
Lot No. : S614943/250909
Date Tested : 09/17/2025
Date of Issue : 09/22/2025

Part Number :
Lot Classification :
Level of Testing :

Test Settings

Amps DCEP	Volts	WFS	Shielding Gas	Electrode Stickout	Temperature		Travel Speed
					Preheat	Interpass	
425	28	NONE	NONE	35mm	85±25°F 30±15°C	300±25°F 150±15°C	13±1 ipm

Mechanical Properties Lab Test #2EJ16

Item	Ult. Tensile Strength	Yield Strength	Elong % in 2 "	Impact Test Temp.	Charpy V-Notch Values ft.lbf
Requirement	-	-	-	-	-
AS WELDED	- psi - MPa	- psi - MPa	-	- °F - °C	- - - Average - (- J)

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

Weld Metal Chemical Composition (%) Ref. No.CA25091704

Elements	C	Mn	P	S	Si	Cu	Nb	V	Cr	Ni	Mo				
Requirement	-	-	-	-	-	-	-	-	-	-	-				
Deposited Metal	0.161	1.38	0.025	0.006	0.721	0.025	0.161	0.16	13.03	2.37	0.93				

Remarks

Production Date :09/09/2025

Hardness Test (HRC): 47

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