

Delivery note no.: 80169000

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

Customer order no.: 2000-002886 / Jon Mi

Quantity delivered: 6,000.00 KG  
Customer: (to be filled in by customer)

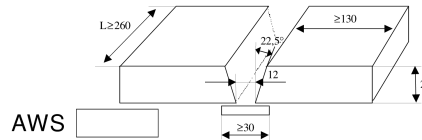
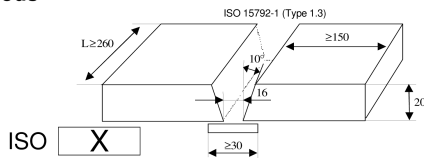
Type: **MEGAFIL 240 M**  
Diameter Ø: **1.2 mm | 0.045"**  
Batch: **082716**

Specification: T 50 6 1Ni M M21 1 H5  
ISO 17632 A: E80C-Ni1 H4  
AWS ASME 5.28:

Current: =+/DCEP 240 A  
Voltage: 28 V  
Welding speed: 35 cm/min  
Shielding gas / Flux: M21(82/18)  
Flow rate: 15 l/min  
Stick out: 15-20 mm  
Position: PA (1G)  
Interpass temp.: 150 °C 302 °F

DB-type certificate: 42.027.10  
TÜV-type certificate: 09805  
Lot classification: T4  
Testing schedule: 1

**Test methods**



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

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,04	0,58	1,31	0,007	0,006	0,028	0,917	0,003	0,106	0,003	0,002	0,002	0,002	0,006
ISO													
	max.	max.			max.	max.	max.		max.			max.	
	0,80	1,40			0,20	0,6 - 1,2	0,20	0,30		0,08		0,05	
AWS													
max.	max.	max.	max.	max.	max.	max.	max.	max.		max.			
0,12	0,80	1,50	0,03	0,03	0,15	0,8 - 1,1	0,30	0,35		0,03			

**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 [MPa]	A [%]	RT	0°C	-20°C	-40°C	-60°C	RT	32°F	-4°F	-40°F	-76°F
as welded	620	550	27										
	min. 560	min. 500	min. 18										
	90 [ksi]	80 [ksi]	27 [%]				120	90				88	66
	min. 81	min. 73	min. 18										

Name: Jutzi  
Date: 26.10.2022

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