

Delivery note no.: 80031829

Customer: Hobart Brothers LLC
11260 Bruckner Drive
Troy, OH 45373

Customer order no.: 119425 / Jon Mitchel

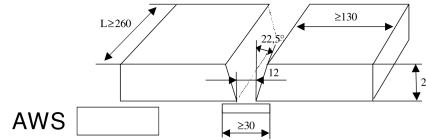
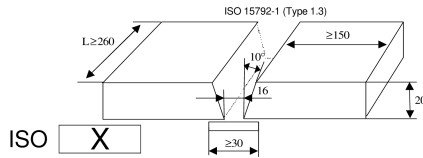
Quantity delivered: 6,144.00 KG
Customer: (to be filled in by customer)

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Type: **MEGAFIL 710 M**
Diameter Ø: **1.2 mm | 0.045"**
Batch: **079625**
Specification:
ISO 17632 A: T 46 6 M M21 1 H5
AWS ASME 5.18: E70C-6M H4
AWS ASME 5.36: E81T15-M21A8-CS1-H4
DB-type certificate: 42.027.05
TÜV-type certificate: 07605
Lot classification: T4
Testing schedule: 1

Current: **±/DCEP** 250 A
Voltage: 27 V
Welding speed: 35-40 cm/min
Shielding gas / Flux: M21(82/18)
Flow rate: 15 l/min
Stick out: 20-15 mm
Position: PA (1G)
Interpass temp.: 150 °C 302 °F

Test methods



ISO 6847 All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,05	0,70	1,46	0,005	0,009	0,020	0,032	0,004	0,162	0,010	0,001	0,018	0,001	0,009
ISO													
		max.			max.	max.	max.	max.		max.		max.	
		2,00			0,20	0,50	0,20	0,30		0,08		0,05	
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			

Mechanical properties of the pure weld metal

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	636	579	28					68					50
	min. 570	min. 460	min. 22					50					37
	[ksi]		[%]					71					52
	92	84	28					63					46
	min. 83	min. 67	min. 22										

Name: Hiereth
Date: 21.08.2019

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