

Delivery note no.: 80064670

Customer: Hobart Brothers LLC.
101 Trade Square East
TROY OH 45373 USA

Customer order no.: PO 119541

Quantity delivered: 2.400 kg

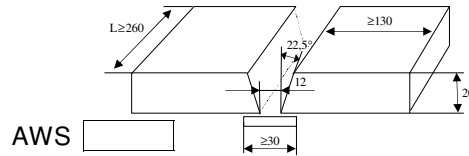
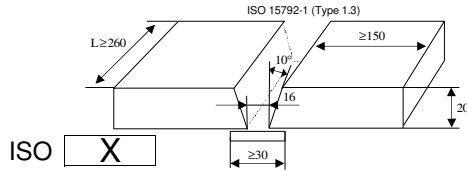
Customer:
(to be filled in by customer)

Quantity delivered:
(to be filled in by customer)

Type: **MEGAFIL 710 M**
 Diameter Ø: **1.4 mm | 0.052"**
 Batch: **020524**
 Specification:
 ISO 17632 A: T 46 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 265 A
 Voltage: 26,8 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 | 0,51 | 1,71 | 0,014 | 0,012 | 0,014 | 0,042 | 0,017 | 0,080 | 0,012 | 0,001 | 0,019 | 0,001 | 0,008 |
| ISO | | | | | | | | | | | | | |
| | | max. 2,00 | | | max. 0,20 | max. 0,50 | max. 0,20 | max. 0,30 | | max. 0,08 | | max. 0,05 | |
| AWS | | | | | | | | | | | | | |
| max. 0,12 | max. 0,90 | max. 1,75 | max. 0,03 | max. 0,03 | max. 0,20 | max. 0,50 | max. 0,30 | max. 0,50 | | max. 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 | 607 | 541 | 26 | | | | | 148 | | | | | 109 |
| | min. 530 | min. 460 | min. 20 | | | | | 153 | | | | | 113 |
| | | | | | | | | 164 | | | | | 121 |
| | 88 | 79 | 26 | | | | | 155 | | | | | 114 |
| | min. 77 | min. 67 | min. 20 | | | | | | | | | | |

Name: Jutzi
Date: 29.05.2020

This document was generated electronically and is valid without signature.