

Delivery note no.: 80110600

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

Customer order no.: 119719 / Jon Mitchel

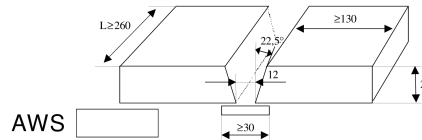
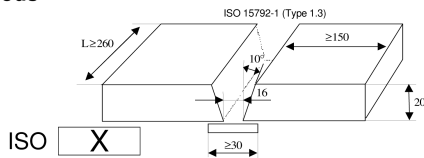
Quantity delivered: 2,000.00 KG
Customer: (to be filled in by customer)

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Type: **MEGAFIL 710 M**
Diameter Ø: **1.6 mm | 1/16"**
Batch: **041651**
Specification: T 46 6 M M21 1 H5
ISO 17632 A: E70C-6M H4
AWS ASME 5.18: E81T15-M21A8-CS1-H4
AWS ASME 5.36: 42.027.05
DB-type certificate: 07605
TÜV-type certificate: T4
Lot classification: 1
Testing schedule:

Current: =+/DCEP 290 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
0,06	0,77	1,56	0,008	0,010	0,029	0,037	0,005	0,095	0,009	0,007	0,003	0,008	0,008
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 [%]	A [%]	RT	0°C	-20°C	-40°C	-60°C	RT	32°F	-4°F	-40°F	-76°F
as welded	614	510	29					130					96
	min. 530	min. 460	min. 20					126					93
	[ksi]	[%]	[%]					143					105
	89	74	29					133					98
	min. 77	min. 67	min. 20										

Name: Jutzi
Date: 30.06.2021

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