

Delivery note no.: 80122144

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

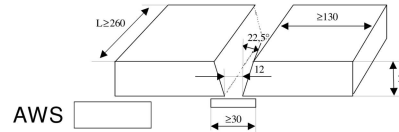
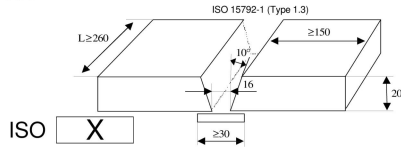
Customer order no.: 119766 / Jon Mitchell

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

Type: **MEGAFIL 710 M**
Diameter Ø: **1.6 mm | 1/16"**
Batch: **081722**
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 290 A
Voltage: 26,5 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	0,85	1,75	0,006	0,007	0,034	0,019	0,005	0,078	0,008	0,009	0,003	0,009	0,007
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	631	538	28					102					75
	min. 530	min. 460	min. 20					63					46
	[ksi]		[%]					98					72
	92	78	28					88					65
	min. 77	min. 67	min. 20										

Name: Gümüş
Date: 09.09.2021

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