

Delivery note no.: 80093351

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

Customer order no.: PO 119645 / Mr. Jon

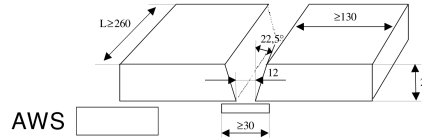
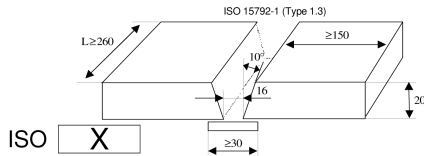
Quantity delivered: 1,000.00 KG  
Customer: (to be filled in by customer)

Quantity delivered: (to be filled in by customer)

Type: **MEGAFIL 710 M**  
Diameter Ø: **1.6 mm | 1/16"**  
Batch: **090653**  
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 270 A  
Voltage: 27,3 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**



**EN 10204 - 3.1: ISO 6847 All weld metal chemical composition (%)**

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,05	0,69	1,46	0,009	0,013	0,019	0,051	0,015	0,114	0,017	0,001	0,005	0,001	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			

**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 [%]	A [%]	RT	0°C	-20°C	-40°C	-60°C	RT	32°F	-4°F	-40°F	-76°F
as welded	600	530	28										
	min. 530	min. 460	min. 20										
	87	77	28				140	100				103	74
	min. 77	min. 67	min. 20										

Name: Jutzi  
Date: 10.12.2020

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