

Delivery note no.: 80099374

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

Customer order no.: 119688 / Jon Mitche

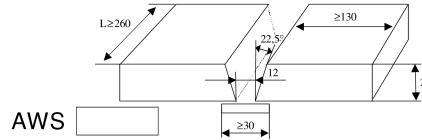
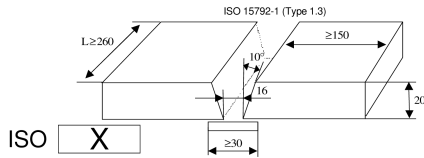
Quantity delivered: 64.00 KG  
 Customer: (to be filled in by customer)

Type: **MEGAFIL 713 R**  
 Diameter Ø: **1.0 mm | 0.039"**  
 Batch: **109684**  
 Specification: T 46 4 P M21 1 H5  
 ISO 17632 A: E71T-1M-J H4  
 AWS ASME 5.20: E71T1-M21A4-CS1-H4  
 AWS ASME 5.36: 42.027.03  
 DB-type certificate: 07602  
 TÜV-type certificate: T4  
 Lot classification: 1  
 Testing schedule:

Quantity delivered: (to be filled in by customer)

Current: =+/DCEP 230 A  
 Voltage: 27 V  
 Welding speed: 35 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
0,08	0,61	1,35	0,005	0,024	0,027	0,041	0,007	0,190	0,004	0,005	0,043	0,001	0,032
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.									
0,12	0,90	1,75	0,03	0,03									

**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	670	643	22				72					53	
	min. 530	min. 460	min. 22				82					60	
							81					60	
	97	93	22				78					58	
	min. 77	min. 67	min. 22										

Name: Jutzi  
Date: 20.12.2019

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