

**ITW Welding**

Spechtal 1a, D-67317 Altleinigen

www.megafil.com

LS- Nr.: 69031

Order No.:

Auftragsnr.:

Commission No.:

Zusatzwerkstofftyp/Consumable:

Sorte/Type:

Abmessung/Diameters Ø:

Normbezeichnung/Specification:

ISO 17632 A/B:

AWS ASME 5.20:

AWS ASME 5.20 M:

DB-Kennblattnummer/-type certificate :

TÜV-Kennblattnummer/-type certificate :

Charge Batch

074550

Requirement:

Position

Wärmebeh.

Heat-treatment

Charge Batch

074550

unbehandelt as welded

Requirement:

Position

Wärmebeh.

Heat-treatment

Charge Batch

074550

Bemerkungen:

Remarks:

Ersteller / Creator :

Datum / Date :

20.08.2014

Ersteller / Creator :

Holzner

Spechtal 1a, D-67317 Altleinigen

**Abnahmeprüfzeugnis / Inspection certificate 3.1 nach EN 10204**

Auszufüllen durch ITW WELDING

To be filled out by ITW WELDING

Auszufüllen durch Händler

To be filled out by dealers

Fülldrahtelektrode / Flux cored wire

MEGAFIL® 713 R

1,2 mm (0,045 inch )

T 46 4 P M 1 H5

E71T-1M-J H4 & E71T-9M-J H4 & E71T-12M-J H4\*

42.027.03

07602

Kunde: Hobart Brothers Company

Customer: 1260 Bruckner Drive

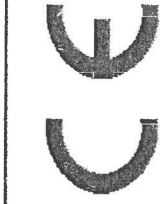
US 45373 Troy, OH

Liefermenge / Quantity delivered: 5296 kg

Kunde:

Customer:

Liefermenge / Quantity delivered:



Stromstärke/Current: 240 A

Spannung/Voltage: 27 V

Schweißgeschw./Welding speed: 35-40 cm/min

Schutzgas/Shielding gas: M21 (75Ar-25CO<sub>2</sub>)

Schutzgasmenge/Flow rate: 15 l/min

Stick out: 15 mm

Position: PA / 1G

Zwischenlagentemp./Interpass temp.: 150 °C

Analyse - Analysis

Position	C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
1	0,047	0,488	1,322	0,010	0,009	0,016	0,290	0,004	0,116	0,003	0,019	0,049	0,027	0,014
	max	max	max	max	max	max	max	max	max	max	max	max	max	max
	0,12	0,9	1,75	0,03	0,03	0,15	0,5	0,2	0,2		0,08		0,05	

Zugversuch - Tensile Test

Position	Rm (MPa)	ksi	min	max	A (%)	min	max	RT	32°F	68°F	RT	-20°C	-4°F	-51°F	-76°F
1	670	97	490	71	22	22	22	86	80	108	80	80	108	86	86
	ksi	ksi	Mpa	ksi	(%)	(%)	(%)	ft-lbf	ft-lbf	ft-lbf	ft-lbf	ft-lbf	ft-lbf	ft-lbf	ft-lbf
	97	89	400	58	22	22	22	64	64	64	64	64	64	64	64
	min	min	min	min	min	min	min	min	min	min	min	min	min	min	min
	490	71	400	58	22	22	22	86	80	108	80	80	108	86	86
	ksi	ksi	Mpa	ksi	(%)	(%)	(%)	ft-lbf	ft-lbf	ft-lbf	ft-lbf	ft-lbf	ft-lbf	ft-lbf	ft-lbf
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