

Delivery note no.: 80257335

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

Customer order no.: 2000-011019 / Jon Mi

Quantity delivered: 1,024.00 KG
Customer: (to be filled in by customer)

Certificate no.: WZ31/71333B/084724/80257335-50

Quantity delivered: (to be filled in by customer)

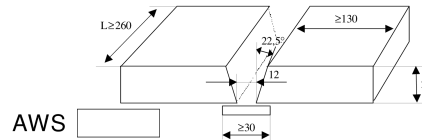
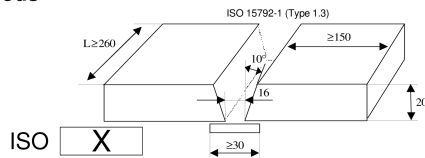
Type: **MEGAFIL 713 R**
Diameter Ø: **1.6 mm | 1/16"**
Batch: **084724**

Specification: T 46 2 P C 1 1 H 5
ISO 17632 A: E71T-1C-J H4
ASME SFA 5.20 / AWS A5.20:

Current: =+/DCEP 270 A
Voltage: 26,5 V
Welding speed: 20-25 cm/min
Shielding gas / Flux: CO2
Flow rate: 15 l/min
Stick out: 20-15 mm
Position: PA (1G)
Interpass temp.: 150 °C 302 °F

The scope of approval can be found on the product labels.

Test methods



All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,05	0,40	1,29	0,010	0,005	0,028	0,203	0,004	0,097	0,001	0,015	0,028	0,008	0,011
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	601	545	28			127					94		
	min. 530	min. 460	min. 20			111					82		
	[ksi]	[%]	[%]			153					113		
	87	79	28			130					96		
	min. 77	min. 67	min. 20										

Name: Jutzi
Date: 02.12.2024

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