

Delivery note no.: 80035602

Customer: Hobart Brothers LLC  
11260 Bruckner Drive  
Troy, OH 45373

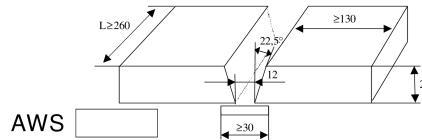
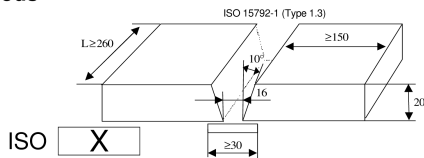
Customer order no.: 119429 / Jon Mitchel

Quantity delivered: 2,048.00 KG  
Customer: (to be filled in by customer)

Type: **MEGAFIL 713 R**  
Diameter Ø: **1.6 mm | 1/16"**  
Batch: **089644**  
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** 280 A  
Voltage: 26.8 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	0,51	1,29	0,020	0,004	0,031	0,241	0,009	0,133	0,007	0,006	0,042	0,001	0,015
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 [MPa]	A [%]	RT	0°C	-20°C	-40°C	-60°C	RT	32°F	-4°F	-40°F	-76°F
as welded	628	562	26				58					43	
	min. 530	min. 460	min. 22				64					47	
	[ksi]	[ksi]	[%]				53					39	
	91	82	26				58					43	
	min. 77	min. 67	min. 22										

Name: Hiereth  
Date: 20.09.2019

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