Doc-no. MF 819R / 3.1 / M / Rev.8

0035 06
Ref. 819
EN 13479:2017

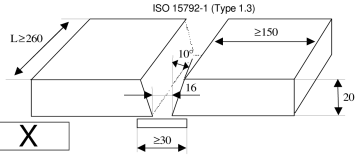
Inspection certificate
EN 10204 Type 3.1

Delivery note no.:	80134823	**Customer:**	Hobart Brothers LLC 1260 Bruckner Drive Troy, OH 45373
Customer order no.:	119826 / Jon Mitchel	**Quantity delivered:** ***Customer:*** *(to be filled in by customer)*	2,048.00 KG
		Quantity delivered: *(to be filled in by customer)*	

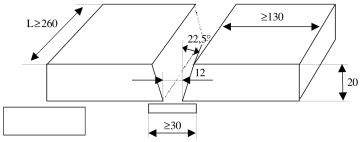
Type:	**MEGAFIL 819 R**						
Diameter Ø:	**1.2 mm | 0.045"**						
Batch:	**071708**						
Specification:		**Current: =+/DCEP**	240	A			
ISO 17632 A:	T 50 6 1Ni P M21 1 H5	**Voltage:**	27	V			
AWS ASME 5.29:	E81T1-Ni1M-J H4	**Welding speed:**	35	cm/min			
AWS ASME 5.36:	E81T1-M21A8-Ni1-H4	**Shielding gas / Flux:**	M21(82/18)				
DB-type certificate:		**Flow rate:**	15	l/min			
TÜV-type certificate:		**Stick out:**	20-15	mm			
Lot classification:	T4	**Position:**	PA (1G)				
Testing schedule:	1	**Interpass temp.:**	150	°C	302	°F	

Test methods

ISO 15792-1 (Type 1.3)



ISO X



AWS

ISO 6847 All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,03	0,46	1,50	0,003	0,007	0,042	0,843	0,005	0,101	0,004	0,019	0,043	0,020	0,005
ISO													

Mechanical properties of the pure weld metal

Heat-treatment	Tensile test ISO 5178 [MPa] Rm	Rp0,2	[%] A	Impact test ISO 9016 VWT 0/b [J] RT	0°C	-20°C	-40°C	-60°C	[ft-lbf] RT	32°F	-4°F	-40°F	-76°F
as welded	646	586	25					84					62
	min. 560	min. 500	min. 18					75					55
	[ksi]		[%]					64					47
	94	85	25					74					55
	min. 81	min. 73	min. 18										

Name: Jutzi
Date: 23.08.2021

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