

Delivery note no.: 80159489

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

Customer order no.: 2000-002266 / Jon Mi

Quantity delivered: 4,800.00 KG
 Customer: (to be filled in by customer)

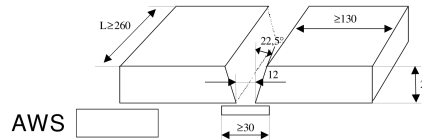
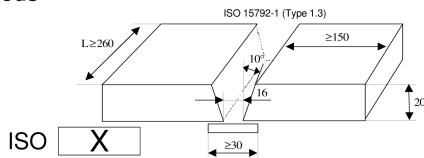
Type: **MEGAFIL 240 M**
 Diameter Ø: **1.2 mm | 0.045"**
 Batch: **062694**

Specification: T 50 6 1Ni M M21 1 H5
 ISO 17632 A: E80C-Ni1 H4
 AWS ASME 5.28:

Current: =+/DCEP 240 A
 Voltage: 27,5 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

DB-type certificate: 42.027.10
 TÜV-type certificate: 09805
 Lot classification: T4
 Testing schedule: 1

Test methods



ISO 6847 All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,04	0,57	1,38	0,009	0,007	0,029	0,944	0,001	0,079	0,004	0,007	0,003	0,000	0,007
ISO													
	max.	max.			max.	max.	max.		max.			max.	
	0,80	1,40			0,20	0,6 - 1,2	0,20	0,30		0,08		0,05	
AWS													
max.	max.	max.	max.	max.	max.	max.	max.			max.			
0,12	0,80	1,50	0,03	0,03	0,15	0,8 - 1,1	0,30	0,35		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	607	533	26					109					80
	min. 560	min. 500	min. 18					101					74
	[ksi]		[%]					109					80
	88	77	26					106					78
	min. 81	min. 73	min. 18										

Name: Jutzi
Date: 24.08.2022

This document was generated electronically and is valid without signature.