



**Certificate of Conformance
to Requirements for Welding Electrode
EN 10204 3.1**

Customer :

Product : SDX EM14K/SWX 150
 Diameter : 5/32"
 Classification : F7A8-EM14K-H8
 Specification : AWS A5.17-'19

Customer P.O.# : 119691
 Lot No. : 210406X64S40/00609
 Date Tested : 04/14/2021
 Date of Issue : 04/15/2021

Part Number :
 Lot Classification :
 Level of Testing :

Test Settings

Amps DCEP	Volts	WFS	Shielding Gas	Electrode Stickout	Temperature		Travel Speed
					Preheat	Interpass	
500	28	43 ipm	NONE	35 mm	85±25°F 30±15°C	300±25°F 150±15°C	16±1 ipm

6 Layers, 2 passes on each layer 1 through 6; 7th Layer, 3 passes on cap layer; Direction reversed on each layer.

Mechanical Properties Lab Test #2AD14

Shielding Gas	Testing Conditions	Ult. Tensile Strength	Yield Strength	Elong % in 2 "	Impact Test Temp.	Charpy V-Notch Values ft.lbf		
NONE	AS WELDED	81071 psi 559 MPa	70119 psi 483 MPa	35	-80 °F -62 °C	112	116	116
						Average	114	(155 J)

Radiographic		Fillet Weld Test						Moisture %
Inspection:	Conforms	Horizontal:	N/A	Vertical:	N/A	Overhead:	N/A	N/A
Bending Test								

Chemical Composition of Wire and Rod (%)

Elements	C	Mn	Si	S	P	Cu	Ti								
Filler Metal	0.09	1.20	0.42	0.003	0.007	0.001	0.07								

Remarks

Production Date :04/06/2021
 Hydrogen Content(ml/100g): 4.3 (according to AWS A4.3; FLUX Re-Drying 350°C×1hr)


 Q.C Section: J.M. Wang

Manufacturing, Certification and Limited Warranty Agreement

Data for the above supplied product are those obtained when welded and tested in accordance with the above specification. All tests for the above classification were satisfied. Other tests and procedures may produce different results. The above supplied product were manufactured by Tien Tai Electrode an ITW Co. located at: No.6 Kaifa 4th Rd., Rende Dist., Tainan City 717, Taiwan R.O.C Hobart Brothers produces welding consumables under continuing quality assurance programs audited and approved by Lloyd's Register Quality Assurance Limited(LRQA)