

Inspection certificate EN 10204 Type 3.1

Delivery note no.: 80172754

Customer order no.: 2000-003407 / Jon Mi

Type: **SubCOR SL 742**

Diameter Ø: **4.0 mm | 5/32"**

Batch: **061689**

Specification: **S 69 6 FB T3Ni2,5CrMo**

ISO 26304 A:

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

Quantity delivered: 1,000.00 KG

Customer:
(to be filled in by customer)

Quantity delivered:
(to be filled in by customer)

DB-type certificate:

TÜV-type certificate:

Current: =+/DCEP 600 A

Voltage: 29 V

Welding speed: 55 cm/min

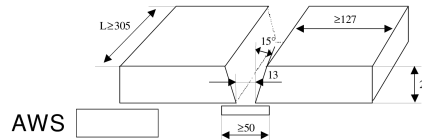
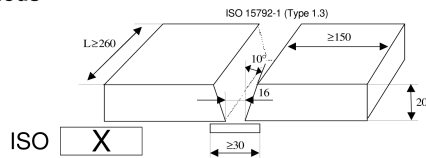
Shielding gas / Flux: SWX150

Stick out: 40 mm

Position: PA (1G)

Interpass temp.: 150 °C 302 °F

Test methods



All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,04	0,36	1,54	0,009	0,010	0,477	2,302	0,314	0,065	0,015	0,003	0,014	0,008	0,008
ISO													
			max.	max.					max.		max.		max.
0,03 - 0,09	0,10 - 0,50	1,20 - 1,70	0,02	0,02	0,40 - 0,70	2,20 - 2,60	0,30 - 0,60		0,02		0,02		0,01
AWS													

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	790	711	18				153	117				113	86
	min. 770	min. 690	min. 17				140	118				103	87
	[ksi]	[%]	[%]				150	128				110	94
	min. 112	min. 100	min. 17				148	121				109	89

Name: Jutzi
Date: 13.12.2022

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