

Customer:	Product Type:	FABCO 70XHP 3/32 60 CL
Customer P.O. No.:	Classification:	E70T-1CJH8,-9CJH8,-12CJH8,-1MJH8,-9MJH8
Order No.:	Specifications:	AWS A5.20
Stock Number: S240929-002	Diameter Tested:	1/16 3/32 in
Lbs. Shipped:	Date Tested:	3/28/2013
Date Generated: 3/29/2013	Diameter Shipped:	3/32 in
Lot Nos. Shipped:		

This is to certify that the product named above and supplied on the referenced order number is of the same classification, manufacturing process, and material requirements as the material which was used for the test that was concluded on the date shown, the results of which are shown below. All tests required by the specifications shown for classification were performed at that time and the material tested met all requirements. It was manufactured and supplied by the Quality System Program of Hobart Brothers, which meets the requirements of ISO 9001, ANSI/AWS A5.01, and other specification and Military requirements, as applicable. This document supplies actual test results of non-specific inspection in conformance with the requirements of EN 10204, type 2.2 certification.

Test Settings

Shielding Medium	Amps / Polarity	Volts	WFS in/min(m/min)	ESO in(mm)	Preheat F(C)	Interpass F(C)	Travel Speed in/min(cm/min)
SG-C 100%CO2	470 / DCEP	30	210 (5.3)	1 (25)	70(21)	300(149)	12 (30.5)
SG-AC-25	470 / DCEP	29	210 (5.3)	1 (25)	70(21)	300(149)	12 (30.5)
SG-AC-25	330 / DCEP	27	360 (9.1)	3/4 (19)	70(21)	300(149)	10 (25.4)
SG-C	330 / SG-C	28	350 (8.9)	3/4 (19)	70(21)	300(149)	10 (25.4)

Mechanical Properties - Tensile

Shielding Medium	Ref. No.	Testing Conditions	Ult. Tensile Strength psi (MPa)	Yield Strength psi (MPa)	Elong.% in 2"
SG-AC-25	PB9665	Aged 48 Hrs 200F	86,000 (592)	73,000 (503)	26
SG-C	PB9667	Aged 48 Hrs 220F	82,000 (562)	70,000 (479)	28
SG-C 100%CO2	PB9683	Aged 48 Hrs 220F	83,000 (574)	70,000 (483)	28
SG-AC-25	PB9684	Aged 48 Hrs 220F	93,000 (639)	78,000 (535)	27

Mechanical Properties - Impact

Shielding Medium	Ref. No.	Testing Conditions	Temp. F (C)	Individuals ft.lb.(J)	Avg. ft.lb.(J)	Type
SG-C	PB9667	As Welded	-40 (-40)	49,39,30 (66,53,41)	39 (53)	Charpy-V-Notch
SG-C 100%CO2	PB9683	As Welded	-40 (-40)	41,40,36 (56,54,49)	39 (53)	Charpy-V-Notch
SG-AC-25	PB9684	As Welded	-40 (-40)	27,19,24 (37,26,33)	23 (32)	Charpy-V-Notch
SG-AC-25	PB9729	As Welded	-40 (-40)	28,28,27 (38,38,37)	28 (38)	Charpy-V-Notch

Ref.No.	Radiographic Inspection	Fillet Weld Test			
PB9665	Conforms	Horizontal :	Conforms	Overhead :	Vertical :
PB9667	Conforms	Horizontal :	Conforms	Overhead :	Vertical :
PB8683	Conforms	Horizontal :	Conforms	Overhead :	Vertical :
PB8684	Conforms	Horizontal :	Conforms	Overhead :	Vertical :

Chemical Analysis

Shielding Medium / Ref. No	C	Mn	P	S	Si	Cu	Cr	V	Ni	Mo	Al	Ti	Nb	Co	B	W	Sn	Fe	Sb	N	Mg	Zn	Be
SG-AC-25 / PB9665	0.02	1.74	0.006	0.007	0.60	0.05	0.05	0.004	0.35	0.01													
SG-C / PB9667	0.03	1.57	0.006	0.008	0.50	0.06	0.05	0.004	0.34	0.01													
SG-C 100%CO2 / PB9683	0.03	1.54	0.012	0.008	0.50	0.06	0.06	0.003	0.34	0.01													
SG-AC-25 / PB9684	0.04	1.68	0.011	0.008	0.57	0.07	0.07	0.003	0.37	0.01													

Diffusible Hydrogen Collected per AWS A4.3

co2	5.5 ml/100g of weld metal for 3/32 in diameter 52% relative humidity
c25	5.5 ml/100g of weld metal for 3/32 in diameter 52% relative humidity



Jon Snyder, Engineer

Certification and Limited Warranty - 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. Hobart Brothers produces welding consumables under continuing quality assurance programs audited and approved by the American Bureau of Shipping ("ABS").