



Product: FabCOR Edge
Diameter: .045"
Shielding Gas: M20-ArC-10
Current/Polarity: DCEP
Classification: E70C-6M H4
Specification: AWS A5.18/A5.18M:2017
Test Completed: 11/28/2022

Certificate of Conformance

For AWS D1.8/D1.8M, Seismic Supplement

This is to certify that the product named is of the same classification, manufacturing process, and material requirements as the material, which was used for the test which was concluded on the date shown, the results of which are shown below. All test required by the code or specifications were performed at that time and the material tested met all requirements. The product was manufactured and supplied by the Quality System Program of Hobart Brothers, which meets the requirements of ISO9001:2015, ANSI/AWS A5.01, and other specification and Military requirements, as applicable.

Test Settings	High Heat Input	Low Heat Input	Lot- # C602130603511	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.1 kJ/in	28.3 kJ/in	Mechanical Properties		80.1 kJ/in	28.3 kJ/in
			Test Reference #		PD8768	PD8765
Voltage	28.5	28.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	81,000 65,200 39 87	93,900 83,600 24 63
Current (amps)	300	260				
WFS (ipm)	400	390				
Travel Speed (ipm)	6.4	16.6				
Stick Out	1/2"	1/2"				
# of passes	7	16				
# of layers	4	6				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # Z622940528121	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.8 kJ/in	28.8 kJ/in	Mechanical Properties		78.4 kJ/in	28.8 kJ/in
			Test Reference #		PD2770	PD2769
Voltage	28.5	28.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	76,800 62,900 32 97	91,100 81,300 26 80
Current (amps)	280	280				
WFS (ipm)	401	390				
Travel Speed (ipm)	6	16.6				
Stick Out	3/4"	3/4"				
# of passes	6	16				
# of layers	4	6				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # G61998	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.3 kJ/in	29.9 kJ/in	Mechanical Properties		79.3 kJ/in	29.9 kJ/in
			Test Reference #		PE5006	PE4998
Voltage	28.5	28.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	78,400 62,500 30 76	87,800 76,700 25 62
Current (amps)	300	275				
WFS (ipm)	440	390				
Travel Speed (ipm)	6.4	15.7				
Stick Out	3/4"	3/4"				
# of passes	8	16				
# of layers	4	6				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Diffusible Hydrogen - Tested in accordance with AWS A5.18/A5.18M, Clause 15 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	G61998	HB6307	3.8 (ml/100g)
7 Day Exposure	G61998	HB6308	4.7 (ml/100g)

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James Owens, Quality Assurance Specialist



Product: FabCOR Edge
Diameter: .052"
Shielding Gas: M20-ArC-15
Current/Polarity: DCEP
Classification: E70C-6M H4
Specification: AWS A5.18/A5.18M:2021
Test Completed: 9/10/2021

Certificate of Conformance

For AWS D1.8/D1.8M, Seismic Supplement

This is to certify that the product named herein is of the same classification, manufacturing process, and material requirements as the material used for the tests completed on the date shown, the results of which are recorded below. All tests required by the code or specifications were performed at that time and the material tested met all requirements. The product was manufactured and supplied by the Quality Management System of Hobart Brothers, which meets the requirements of ISO 9001:2015, ANSI/AWS A5.01, and other specification and Military requirements, as applicable.

Test Settings	High Heat Input	Low Heat Input	Lot-# F62097	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	77.7 kJ/in	26.8 kJ/in			77.7 kJ/in	26.8 kJ/in
			Mechanical Properties			
			Test Reference #		PE2945	PE2942
Voltage	32	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	80,900 65,300 29 105	89,100 79,600 26 83
Current (amps)	425	265				
WFS (ipm)	530	260				
Travel Speed (ipm)	10.5	16				
Stick Out	3/4"	3/4"				
# of passes	7	16				
# of layers	4	6				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot-# B611551208253	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.7 kJ/in	27.1 kJ/in			79.7 kJ/in	27.1 kJ/in
			Mechanical Properties			
			Test Reference #		PD6627	PD6726
Voltage	32	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	78,600 61,800 31 102	81,100 78,800 25 81
Current (amps)	440	258				
WFS (ipm)	540	255				
Travel Speed (ipm)	10.6	15				
Stick Out	3/4"	3/4"				
# of passes	8	20				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot-# X617870920122	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.0 kJ/in	26.0 kJ/in			79.0 kJ/in	26.0 kJ/in
			Mechanical Properties			
			Test Reference #		PC7305	PC7304
Voltage	32	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	83,600 67,700 25 91	89,300 79,900 26 78
Current (amps)	440	258				
WFS (ipm)	540	255				
Travel Speed (ipm)	10.7	14.4				
Stick Out	3/4"	3/4"				
# of passes	6	20				
# of layers	3	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Diffusible Hydrogen - Tested in accordance with AWS A5.18/A5.18M, Clause 15 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	F62097	HB5115	1.7 (ml/100g)
7 Day Exposure	F62097	HB5132	2.4 (ml/100g)

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David A. Thomas, Quality Specialist



Product: FabCOR Edge
Diameter: .052"
Shielding Gas: M21-ArC-25
Current/Polarity: DCEP
Classification: E70C-6M H4
Specification: AWS A5.18/A5.18M:2017
Test Completed: 11/14/2019

Certificate of Conformance

For AWS D1.8/D1.8M, Seismic Supplement

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Test Settings	High Heat Input	Low Heat Input	Lot - # C616810903163	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.4 kJ/in	27.8 kJ/in	Mechanical Properties		78.4 kJ/in	27.8 kJ/in
			Test Reference #		PD8768	PD8773
Voltage	32	28.5	Tensile Strength (psi)	70,000	77,000	85,600
Current (amps)	425	275	Yield Strength (psi)	58,000	61,700	75,100
WFS (ipm)	460	260	Elongation (%)	22	29	25
Travel Speed (ipm)	7	16.9	Average Charpy V-notch			
Stick Out	1/2"	3/4"	Impact Properties ft•lbs @	40	89	67
# of passes	7	19	+70 °F			
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot - # Z623570902111	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.3 kJ/in	26.2 kJ/in	Mechanical Properties		80.3 kJ/in	26.2 kJ/in
			Test Reference #		PD2791	PD2789
Voltage	31.5	28.5	Tensile Strength (psi)	70,000	78,400	84,200
Current (amps)	425	260	Yield Strength (psi)	58,000	62,000	71,900
WFS (ipm)	540	260	Elongation (%)	22	29	28
Travel Speed (ipm)	10	17	Average Charpy V-notch			
Stick Out	3/4"	3/4"	Impact Properties ft•lbs @	40	101	73
# of passes	6	16	+70 °F			
# of layers	3	6				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot - # X617870920122	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.5 kJ/in	26.2 kJ/in	Mechanical Properties		78.5 kJ/in	26.2 kJ/in
			Test Reference #		PC2457	PC2470
Voltage	32	27	Tensile Strength (psi)	70,000	74,400	90,600
Current (amps)	425	258	Yield Strength (psi)	58,000	60,700	82,200
WFS (ipm)	475	255	Elongation (%)	22	31	26
Travel Speed (ipm)	10.4	15.4	Average Charpy V-notch			
Stick Out	3/4"	3/4"	Impact Properties ft•lbs @	40	110	68
# of passes	8	20	+70 °F			
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Diffusible Hydrogen - Tested in accordance with AWS A5.18/A5.18M, Clause 15 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	C616810903163	HB3686	2.1 (ml/100g)
7 Day Exposure	C616810903163	HB3738	4.7 (ml/100g)

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David A. Thomas, Quality Assurance Representative



Product: FabCOR Edge
Diameter: 1/16"
Shielding Gas: M20-ArC-10
Current/Polarity: DCEP
Classification: E70C-6M H4
Specification: AWS A5.18/A5.18M:2017
Test Completed: 6/30/2023

Certificate of Conformance

For AWS D1.8/D1.8M, Seismic Supplement

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Test Settings	High Heat Input	Low Heat Input	Lot- # D61126	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.9 kJ/in	30.4 kJ/in			78.9 kJ/in	30.4 kJ/in
			Mechanical Properties			
			Test Reference #		PE1397	PE1398
Voltage	28	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	74,400 58,900 34 136	88,900 78,900 28 102
Current (amps)	345	300				
WFS (ipm)	250	210				
Travel Speed (ipm)	7.35	16				
Stick Out	3/4"	3/4"				
# of passes	8	16				
# of layers	5	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # C617290303253	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.0 kJ/in	29.2 kJ/in			80.0 kJ/in	29.2 kJ/in
			Mechanical Properties			
			Test Reference #		PE1388	PE1455
Voltage	28	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	74,600 59,100 32 113	88,400 77,400 26 89
Current (amps)	350	300				
WFS (ipm)	240	210				
Travel Speed (ipm)	7.35	16				
Stick Out	3/4"	3/4"				
# of passes	8	15				
# of layers	5	6				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # G63740	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.0 kJ/in	30.6 kJ/in			81.0 kJ/in	30.6 kJ/in
			Mechanical Properties			
			Test Reference #		PE6238	PE6239
Voltage	28	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	76,600 61,300 33 103	86,400 74,300 25 93
Current (amps)	345	260				
WFS (ipm)	250	160				
Travel Speed (ipm)	8	13				
Stick Out	3/4"	3/4"				
# of passes	8	18				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Diffusible Hydrogen - Tested in accordance with AWS A5.18/A5.18M, Clause 15 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	G63740	HB6853	2.3 (ml/100g)
7 Day Exposure	G63740	HB6924	4.1 (ml/100g)

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James Owens, Quality Assurance Specialist



Product: FabCOR Edge
Diameter: 1/16"
Shielding Gas: M21-ArC-17
Current/Polarity: DCEP
Classification: E70C-6M H4
Specification: AWS A5.18/A5.18M:2017
Test Completed: 6/30/2023

Certificate of Conformance

For AWS D1.8/D1.8M, Seismic Supplement

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Test Settings	High Heat Input	Low Heat Input	Lot- # C623761006251	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.2 kJ/in	23.9 kJ/in	Mechanical Properties		80.2 kJ/in	23.9 kJ/in
			Test Reference #		PE1928	PE1915
Voltage	28	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	77,400 61,500 30 84	91,100 81,400 26 70
Current (amps)	420	250				
WFS (ipm)	330	170				
Travel Speed (ipm)	8.8	15.7				
Stick Out	3/4"	3/4"				
# of passes	7	20				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # A618810316172	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.2 kJ/in	25.7 kJ/in	Mechanical Properties		81.2 kJ/in	25.7 kJ/in
			Test Reference #		PD5307	PD5244
Voltage	28	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	76,300 59,200 31 102	86,600 75,100 26 73
Current (amps)	420	260				
WFS (ipm)	320	175				
Travel Speed (ipm)	8.8	15.2				
Stick Out	3/4"	3/4"				
# of passes	7	20				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # G63740	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	84.0 kJ/in	28.7 kJ/in	Mechanical Properties		84.0 kJ/in	28.7 kJ/in
			Test Reference #		PE6240	PD5383
Voltage	29	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	79,600 64,900 31 97	84,000 72,500 28 82
Current (amps)	420	260				
WFS (ipm)	350	160				
Travel Speed (ipm)	9	13				
Stick Out	3/4"	3/4"				
# of passes	8	21				
# of layers	4	8				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Diffusible Hydrogen - Tested in accordance with AWS A5.18/A5.18M, Clause 15 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	G63740	HB6852	2.7 (ml/100g)
7 Day Exposure	G63740	HB6925	3.9 (ml/100g)

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Jamse Owens, Quality Assurance Specialist



Product: FabCOR Edge
Diameter: 1/16"
Shielding Gas: M21-ArC-25
Current/Polarity: DCEP
Classification: E70C-6M H4
Specification: AWS A5.18/A5.18M:2017
Test Completed: 12/19/2022

Certificate of Conformance

For AWS D1.8/D1.8M, Seismic Supplement

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Test Settings	High Heat Input	Low Heat Input	Lot- # C61729	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.5 kJ/in	30.7 kJ/in	Mechanical Properties		80.5 kJ/in	30.7 kJ/in
			Test Reference #		PD8847	PD8837
Voltage	29	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	74,400 60,800 31.6 114	84,900 73,100 27.1 73
Current (amps)	375	275				
WFS (ipm)	270	175				
Travel Speed (ipm)	8	14.5				
Stick Out	1/2-3/4"	1/2-3/4"				
# of passes	7	20				
# of layers	5	8				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # C61736	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	82.5 kJ/in	30.8 kJ/in	Mechanical Properties		82.5 kJ/in	30.8 kJ/in
			Test Reference #		PD8848	PD8840
Voltage	29	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	74,900 59,800 30.9 104	85,300 75,800 26.4 65
Current (amps)	380	275				
WFS (ipm)	285	170				
Travel Speed (ipm)	8	14.5				
Stick Out	1/2-3/4"	1/2-3/4"				
# of passes	7	20				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # G60184	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.4 kJ/in	30.1 kJ/in	Mechanical Properties		79.4 kJ/in	30.1 kJ/in
			Test Reference #		PE3767	PE3771
Voltage	29	28	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	79,100 59,800 29.6 82	81,000 68,900 28.3 114
Current (amps)	430	275				
WFS (ipm)	350	190				
Travel Speed (ipm)	9.2	15.4				
Stick Out	1/2-3/4"	1/2-3/4"				
# of passes	8	20				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Diffusible Hydrogen - Tested in accordance with AWS A5.18/A5.18M, Clause 15 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	G61901	HB6377	1.5 (ml/100g)
7 Day Exposure	G61901	HB6402	1.6 (ml/100g)

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James Owens, Quality Assurance Specialist