

Delivery note no.: 80223270

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

Customer order no.: 2000-007540

Quantity delivered: 11,264.00 KG  
Customer: (to be filled in by customer)

Certificate no.: WZ31/71015B/024616/80223270-10

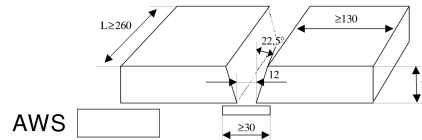
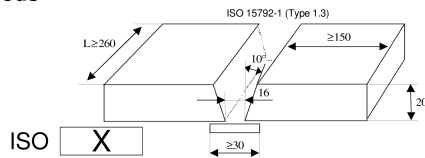
Quantity delivered: (to be filled in by customer)

Type: **MEGAFIL 710 M**  
Diameter Ø: **1.2 mm | 0.045"**  
Batch: **024616**

Specification: T 46 6 M M21 1 H5  
ISO 17632 A: E70C-6M H4  
AWS A5.18:  
ASME SFA 5.18  
DB-type certificate: 42.027.05  
TÜV-type certificate: 07605

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

**Test methods**



**All weld metal chemical composition (%)**

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,05	0,64	1,46	0,012	0,006	0,026	0,020	0,004	0,124	0,005	0,005	0,015	0,000	0,006
ISO													
		max.			max.	max.	max.	max.		max.		max.	
		2,00			0,20	0,50	0,20	0,30		0,08		0,05	
AWS													
max.	max.	max.	max.	max.	max.	max.	max.	max.		max.			
0,12	0,90	1,75	0,03	0,03	0,20	0,50	0,30	0,50		0,08			

**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	609	552	27					136					100
	min. 530	min. 460	min. 20					112					82
	[ksi]	[%]	[%]					131					96
	88	80	27					126					93
	min. 77	min. 67	min. 20										

Name: Jutzi  
Date: 17.04.2024

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