



**Certificate of Conformance
to Requirements for Welding Electrode**

Product Type: **SUBCOR 100F3-S**
 Classification: **ECF3**
 Specifications: **AWS A5.23; ASME SFA5.23**
 Diameter Tested: **5/32"**
 Date Tested: **8/8/2024**
 Date Generated: **8/13/2024**

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.

THE STEEL USED IN THIS LOT OF MATERIAL WAS MELTED AND MANUFACTURED IN THE U.S.A.

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)
HN-590 (F10A6-ECF3-F3 H8)	550 / DCEP	28.5	62 (1.6)	1.25 (32)	300(149)	325(163)	16 (40.6)
HN-521 (F9A6-ECF3-F3 H8)	550 / DCEP	28.5	62 (1.6)	1.25 (32)	300(149)	325(163)	16 (40.6)

Mechanical Properties - Tensile

Shielding Medium	Ref. No.	Testing Conditions	Ult. Tensile Strength psi (MPa)	Yield Strength psi (MPa)	Elong.% in 2"
HN-590 (F10A6-ECF3-F3 H8)	PE8159	As Welded	103,000 (710)	92,000 (636)	25
HN-521 (F9A6-ECF3-F3 H8)	PE8306	Aged 48 Hrs 220F	102,000 (703)	91,000 (626)	23

Mechanical Properties - Impact

Shielding Medium	Ref. No.	Testing Conditions	Temp. F (C)	Individuals ft.lb.(J)	Avg. ft.lb.(J)	Type
HN-590 (F10A6-ECF3-F3 H8)	pe8159	As Welded	-60 (-51)	35,36,39 (47,49,53)	37 (50)	Charpy-V-Notch
HN-521 (F9A6-ECF3-F3 H8)	PE8306	As Welded	-60 (-51)	44,51,44 (60,69,60)	46 (63)	Charpy-V-Notch

Ref.No.	Radiographic Inspection	Fillet Weld Test			
		Horizontal :	Overhead :	Vertical :	Vertical :
PE8159	Conforms				
PE8306	Conforms				

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	Sb	As
HN-590 (F10A6-ECF3-F3 H8) / PE8159	0.05	1.95	0.016	0.009	0.38	0.05	0.04		0.83	0.48					0.0008										
HN-521 (F9A6-ECF3-F3 H8) / PE8306	0.08	1.54	0.009	0.005	0.47	0.04	0.04		0.90	0.47					0.0015										

Diffusible Hydrogen Collected per AWS A4.3

HN-590 (F10A6-ECF3-F3 H8)	5.3 ml/100g of weld metal for 5/32 in diameter 53% relative humidity
HN-521 (F9A6-ECF3-F3 H8)	5.5 ml/100g of weld metal for 5/32 in diameter 63% relative humidity

James A. Owens

James A. Owens, Q.A. Specialist

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.