



Product: FabCOR Edge Ni1
Diameter: .052"
Shielding Gas: M20-ArC-10
Current/Polarity: DCEP
Classification: E80C-Ni1 H4
Specification: AWS A5.28/A5.28M:2017
Test Completed: 6/18/2024

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 ISO 9001:2015, ANSI/AWS A5.01, and other specification and Military requirements, as applicable.

Test Settings	High Heat Input	Low Heat Input	Lot- # D67012120231	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.8 kJ/in	26.0 kJ/in	Mechanical Properties		80.8 kJ/in	26.0 kJ/in
			Test Reference #		PE2499	PE2488
Voltage	30	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	86,000 73,500 27 107	90,700 83,100 26 89
Current (amps)	440	260				
WFS (ipm)	540	255				
Travel Speed (ipm)	10.1	15.3				
Stick Out	5/8"	5/8"				
# of passes	8	19				
# 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- # C024712116	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.8 kJ/in	26.0 kJ/in	Mechanical Properties		80.8 kJ/in	26.0 kJ/in
			Test Reference #		PE2545	PE2540
Voltage	30	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	85,000 72,000 32 91	91,900 84,500 24 85
Current (amps)	440	260				
WFS (ipm)	540	270				
Travel Speed (ipm)	9.8	15.3				
Stick Out	5/8"	5/8"				
# of passes	8	19				
# of layers	3	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- # H04219	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78 kJ/in	28.6 kJ/in	Mechanical Properties		78 kJ/in	28.6 kJ/in
			Test Reference #		PE8165	PE8166
Voltage	30	26.2	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	84,500 69,000 30 90	95,500 88,100 25 88
Current (amps)	403	259				
WFS (ipm)	540	265				
Travel Speed (ipm)	9.3	14.2				
Stick Out	3/4"	3/4"				
# of passes	7	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 A5.28/A5.28M, Clause 14 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	H01935	HB7548	4 (ml/100g)
7 Day Exposure	H01935	HB7593	3 (ml/100g)

The information contained or otherwise referenced herein is presented without guarantee or warranty. Hobart Brothers LLC expressly disclaims any liability incurred from any reliance thereon. Data for the above-supplied product are those obtained during the welding process and tested in accordance with the above specification with electrodes of the same manufacturing processes and material requirements. All tests for the above classification were performed satisfactorily. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers. Refer to the Hobart Brothers website at www.hobartbrothers.com for current Safety Data Sheets ("SDS").

James Owens, Quality Assurance Specialist