



**Product:** FabCOR Edge XP  
**Diameter:** .045"  
**Shielding Gas:** M20-ArC-10  
**Current/Polarity:** DCEP  
**Classification:** E70C-6M H4  
**Specification:** AWS A5.18/A5.18M:2017  
**Test Completed:** 6/13/2024

## 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- # D670911005	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.8 kJ/in	27.8 kJ/in			78.8 kJ/in	27.8 kJ/in
			<b>Mechanical Properties</b>			
			Test Reference #		PE2254	PE2257
Voltage	27	25.5	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 65,900 27 97	88,600 77,400 26 92
Current (amps)	350	280				
WFS (ipm)	575	385				
Travel Speed (ipm)	7.2	15.4				
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				

Test Settings	High Heat Input	Low Heat Input	Lot- # F62327	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.1 kJ/in	29.8 kJ/in			81.1 kJ/in	29.8 kJ/in
			<b>Mechanical Properties</b>			
			Test Reference #		PE2212	PE2210
Voltage	27	25.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	77,600 60,800 30 80	84,500 72,500 28 68
Current (amps)	350	280				
WFS (ipm)	560	385				
Travel Speed (ipm)	7.0	14.44				
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- # J90215	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.5 kJ/in	27.4 kJ/in			79.5 kJ/in	27.4 kJ/in
			<b>Mechanical Properties</b>			
			Test Reference #		PE8132	PE2195
Voltage	28	28	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	77,700 60,000 31 98	90,400 80,200 25 76
Current (amps)	300	265				
WFS (ipm)	425	380				
Travel Speed (ipm)	6.3	16.2				
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 A5.18/A5.18M, Clause 15  
& Extended Exposure - in accordance with AWS D1.8/D1.8M**

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	J90215	HB7504	2 (ml/100g)
7 Day Exposure	J90215	HB7525	2 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCOR Edge XP  
**Diameter:** .045"  
**Shielding Gas:** M21-ArC-25  
**Current/Polarity:** DCEP  
**Classification:** E70C-6M H4  
**Specification:** AWS A5.18/A5.18M:2017  
**Test Completed:** 6/11/2024

## Certificate of Conformance

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

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Test Settings	High Heat Input	Low Heat Input	Lot- # D670911005	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.6 kJ/in	27.5 kJ/in	<b>Mechanical Properties</b>		81.6 kJ/in	27.5 kJ/in
			Test Reference #		PE2252	PE2261
Voltage	28	26	Tensile Strength (psi)	70,000	79,100	85,500
Current (amps)	340	270	Yield Strength (psi)	58,000	62,600	74,100
WFS (ipm)	560	400	Elongation (%)	22	29	26
Travel Speed (ipm)	7.0	15.3	Average Charpy V-notch			
Stick Out	3/4"	3/4"	Impact Properties ft•lbs @	40	88	78
# of passes	8	16	+70 °F			
# 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- # F62327	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	82.5 kJ/in	29.2 kJ/in	<b>Mechanical Properties</b>		82.5 kJ/in	29.2 kJ/in
			Test Reference #		PE2211	PE2209
Voltage	28	26	Tensile Strength (psi)	70,000	76,300	82,200
Current (amps)	350	275	Yield Strength (psi)	58,000	59,900	71,500
WFS (ipm)	560	370	Elongation (%)	22	29	27
Travel Speed (ipm)	7.14	14.83	Average Charpy V-notch			
Stick Out	3/4"	3/4"	Impact Properties ft•lbs @	40	71	54
# of passes	6	18	+70 °F			
# 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- # J90215	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.75 kJ/in	28.4 kJ/in	<b>Mechanical Properties</b>		81.75 kJ/in	28.4 kJ/in
			Test Reference #		PE7889	PE8118
Voltage	29	29	Tensile Strength (psi)	70,000	73,800	87,100
Current (amps)	300	265	Yield Strength (psi)	58,000	59,500	74,800
WFS (ipm)	425	380	Elongation (%)	22	32	25
Travel Speed (ipm)	6.4	16.2	Average Charpy V-notch			
Stick Out	3/4"	3/4"	Impact Properties ft•lbs @	40	90	76
# of passes	7	18	+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	J90215	HB7503	1 (ml/100g)
7 Day Exposure	J90215	HB7526	2 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCOR Edge XP  
**Diameter:** .052"  
**Shielding Gas:** M20-ArC-10  
**Current/Polarity:** DCEP  
**Classification:** E70C-6M H4  
**Specification:** AWS A5.18/A5.18M:2017  
**Test Completed:** 6/26/2024

**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- # F624251201	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.4 kJ/in	28.2 kJ/in	<b>Mechanical Properties</b>		80.4 kJ/in	28.2 kJ/in
			Test Reference #		PE2262	PE2253
Voltage	29.5	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	75,900 59,800 31 103	83,300 71,800 26 76
Current (amps)	350	275				
WFS (ipm)	415	265				
Travel Speed (ipm)	7.7	15.2				
Stick Out	3/4"	3/4"				
# of passes	6	16				
# 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- # D670121202031	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.3 kJ/in	29.4 kJ/in	<b>Mechanical Properties</b>		79.3 kJ/in	29.4 kJ/in
			Test Reference #		PE2229	PE2227
Voltage	27	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	76,100 61,500 33 107	85,700 75,100 26 82
Current (amps)	375	275				
WFS (ipm)	420	270				
Travel Speed (ipm)	7.68	14.1				
Stick Out	3/4"	3/4"				
# of passes	7	17				
# 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- # H94483	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.1 kJ/in	27.9 kJ/in	<b>Mechanical Properties</b>		79.1 kJ/in	27.9 kJ/in
			Test Reference #		PE8190	PE8182
Voltage	27	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	79,500 63,800 31 77	88,100 77,300 27 48
Current (amps)	375	275				
WFS (ipm)	415	275				
Travel Speed (ipm)	7.85	15.3				
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 A5.18/A5.18M, Clause 15**  
**& Extended Exposure - in accordance with AWS D1.8/D1.8M**

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	H94483	HB7492	4 (ml/100g)
7 Day Exposure	H94483	HB7527	3 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCOR Edge XP  
**Diameter:** .052"  
**Shielding Gas:** M20-ArC-15  
**Current/Polarity:** DCEP  
**Classification:** E70C-6M H4  
**Specification:** AWS A5.18/A5.18M:2017  
**Test Completed:** 6/26/2024

## Certificate of Conformance

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

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Test Settings	High Heat Input	Low Heat Input	Lot - # F62931	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.2 kJ/in	29.6 kJ/in	<b>Mechanical Properties</b>		80.2 kJ/in	29.6 kJ/in
			Test Reference #		PE2286	PE2287
Voltage	27.5	25.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	72,500 58,500 32 84	80,400 68,600 27 64
Current (amps)	375	275				
WFS (ipm)	420	270				
Travel Speed (ipm)	7.72	14.34				
Stick Out	3/4"	3/4"				
# of passes	7	18				
# 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 - # D670121202031	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.0 kJ/in	29.2 kJ/in	<b>Mechanical Properties</b>		80.0 kJ/in	29.2 kJ/in
			Test Reference #		PE2276	PE2275
Voltage	27.5	25.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	75,200 59,500 30 95	82,600 70,700 27 81
Current (amps)	375	275				
WFS (ipm)	420	275				
Travel Speed (ipm)	7.74	14.47				
Stick Out	3/4"	3/4"				
# of passes	7	18				
# 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 - # H94483	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.5 kJ/in	30 kJ/in	<b>Mechanical Properties</b>		79.5 kJ/in	30 kJ/in
			Test Reference #		PE8194	PE8196
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	78,200 61,700 31 87	85,000 73,400 28 75
Current (amps)	350	275				
WFS (ipm)	420	275				
Travel Speed (ipm)	7.1	14.8				
Stick Out	3/4"	3/4"				
# of passes	6	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	H94483	HB7490	4 (ml/100g)
7 Day Exposure	H94483	HB7528	3 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCOR Edge XP  
**Diameter:** .052"  
**Shielding Gas:** M21-ArC-25  
**Current/Polarity:** DCEP  
**Classification:** E70C-6M H4  
**Specification:** AWS A5.18/A5.18M:2017  
**Test Completed:** 6/26/2024

## Certificate of Conformance

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

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Test Settings	High Heat Input	Low Heat Input	Lot - # D670121201031	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.2 kJ/in	29.5 kJ/in	<b>Mechanical Properties</b>		81.2 kJ/in	29.5 kJ/in
			Test Reference #		PE2228	PE2226
Voltage	29.5	27	Tensile Strength (psi)	70,000	71,800	82,900
Current (amps)	350	275	Yield Strength (psi)	58,000	57,600	72,300
WFS (ipm)	410	270	Elongation (%)	22	32	26
Travel Speed (ipm)	7.65	15.2	Average Charpy V-notch			
Stick Out	3/4"	3/4"	Impact Properties ft•lbs @	40	102	71
# of passes	7	17	+70 °F			
# 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 - # F624251201	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.4 kJ/in	28.7 kJ/in	<b>Mechanical Properties</b>		78.4 kJ/in	28.7 kJ/in
			Test Reference #		PE2200	PE2198
Voltage	29.5	27	Tensile Strength (psi)	70,000	72,600	81,200
Current (amps)	350	275	Yield Strength (psi)	58,000	58,100	69,800
WFS (ipm)	410	265	Elongation (%)	22	31	26
Travel Speed (ipm)	7.9	15.5	Average Charpy V-notch			
Stick Out	3/4"	3/4"	Impact Properties ft•lbs @	40	81	51
# of passes	6	17	+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 - # H94483	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.5 kJ/in	29.4 kJ/in	<b>Mechanical Properties</b>		81.5 kJ/in	29.4 kJ/in
			Test Reference #		PE8209	PE8220
Voltage	29	27	Tensile Strength (psi)	70,000	76,700	82,800
Current (amps)	350	275	Yield Strength (psi)	58,000	60,900	69,800
WFS (ipm)	425	265	Elongation (%)	22	30	29
Travel Speed (ipm)	7.4	14.72	Average Charpy V-notch			
Stick Out	3/4"	3/4"	Impact Properties ft•lbs @	40	91	74
# of passes	6	17	+70 °F			
# 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	H94483	HB7493	3 (ml/100g)
7 Day Exposure	H94483	HB7529	3 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCOR Edge XP  
**Diameter:** .052"  
**Shielding Gas:** Ozoline C8  
**Current/Polarity:** DCEP  
**Classification:** E70C-6M H4  
**Specification:** AWS A5.18/A5.18M:2017  
**Test Completed:** 6/26/2024

**Certificate of Conformance**  
**For AWS D1.8/D1.8M, Seismic Supplement**

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Test Settings	High Heat Input	Low Heat Input	Lot- # F64777	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	77.3 kJ/in	29.5 kJ/in	<b>Mechanical Properties</b>		77.3 kJ/in	29.5 kJ/in
			Test Reference #		PE3175	PE3176
Voltage	29	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	73,000 58,000 30 56	85,000 74,000 26 68
Current (amps)	350	300				
WFS (ipm)	410	300				
Travel Speed (ipm)	7.89	15.91				
Stick Out	1"	3/4"				
# of passes	7	15				
# 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- # F65403	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.5 kJ/in	29.7 kJ/in	<b>Mechanical Properties</b>		78.5 kJ/in	29.7 kJ/in
			Test Reference #		PE3189	PE3190
Voltage	29	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	76,000 60,000 33 65	88,000 77,000 26 88
Current (amps)	350	300				
WFS (ipm)	410	300				
Travel Speed (ipm)	7.92	15.83				
Stick Out	1"	1"				
# of passes	7	15				
# 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- # H94483	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.7 kJ/in	30.9 kJ/in	<b>Mechanical Properties</b>		78.7 kJ/in	30.9 kJ/in
			Test Reference #		PE8226	PE8227
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	80,400 64,100 31 77	88,300 75,200 26 80
Current (amps)	350	300				
WFS (ipm)	410	340				
Travel Speed (ipm)	7.4	15.1				
Stick Out	3/4"	3/4"				
# of passes	7	15				
# 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	H94483	HB7502	3 (ml/100g)
7 Day Exposure	H94483	HB7530	4 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCOR Edge XP  
**Diameter:** 1/16"  
**Shielding Gas:** M20-ArC-10  
**Current/Polarity:** DCEP  
**Classification:** E70C-6M H4  
**Specification:** AWS A5.18/A5.18M:2017  
**Test Completed:** 6/19/2024

## Certificate of Conformance

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

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Test Settings	High Heat Input	Low Heat Input	Lot - # J60188	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.7 kJ/in	31.4 kJ/in	<b>Mechanical Properties</b>		79.7 kJ/in	31.4 kJ/in
			Test Reference #		PE8170	PE8169
Voltage	26	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	78,200 61,100 32 97	86,400 7,100 27 84
Current (amps)	375	300				
WFS (ipm)	295	220				
Travel Speed (ipm)	7.3	14.9				
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 - # F623171301	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.3 kJ/in	30.8 kJ/in	<b>Mechanical Properties</b>		80.3 kJ/in	30.8 kJ/in
			Test Reference #		PE2339	PE2299
Voltage	26.5	30	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	73,400 58,500 31 80	79,400 67,000 27 67
Current (amps)	375	350				
WFS (ipm)	295	200				
Travel Speed (ipm)	7.45	15.0				
Stick Out	3/4"	7/8"				
# of passes	7	16				
# 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 - # F62351	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.4 kJ/in	29.8 kJ/in	<b>Mechanical Properties</b>		81.4 kJ/in	29.8 kJ/in
			Test Reference #		PE2387	PE2372
Voltage	26.5	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	75,300 59,800 30 85	85,400 73,800 27 79
Current (amps)	375	300				
WFS (ipm)	295	220				
Travel Speed (ipm)	7.38	15.7				
Stick Out	1"	1"				
# of passes	7	17				
# 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	J60188	HB7470	4 (ml/100g)
7 Day Exposure	J60188	HB7507	4 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCOR Edge XP  
**Diameter:** 1/16"  
**Shielding Gas:** M20-ArC-15  
**Current/Polarity:** DCEP  
**Classification:** E70C-6M H4  
**Specification:** AWS A5.18/A5.18M:2017  
**Test Completed:** 6/19/2024

## 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 - # J60188	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.3 kJ/in	29.3 kJ/in	<b>Mechanical Properties</b>		80.3 kJ/in	29.3 kJ/in
			Test Reference #		PE8152	PE8147
Voltage	27	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	76,500 60,900 34 94	82,700 71,400 27 88
Current (amps)	350	275				
WFS (ipm)	275	190				
Travel Speed (ipm)	7	14.9				
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				

Test Settings	High Heat Input	Low Heat Input	Lot - # F623171301	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.6 kJ/in	30.6 kJ/in	<b>Mechanical Properties</b>		80.6 kJ/in	30.6 kJ/in
			Test Reference #		PE2344	PE2358
Voltage	27	26.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	72,400 58,600 32 74	78,600 65,700 27 87
Current (amps)	360	285				
WFS (ipm)	275	191				
Travel Speed (ipm)	7.24	14.85				
Stick Out	3/4"	3/4"				
# of passes	7	17				
# 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 - # F62351	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.0 kJ/in	30.3 kJ/in	<b>Mechanical Properties</b>		78.0 kJ/in	30.3 kJ/in
			Test Reference #		PE2385	PE2384
Voltage	27	26.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	73,600 59,400 30 77	80,300 68,900 27 82
Current (amps)	360	285				
WFS (ipm)	275	191				
Travel Speed (ipm)	7.52	15.0				
Stick Out	3/4"	3/4"				
# of passes	7	17				
# 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	J60188	HB7469	4 (ml/100g)
7 Day Exposure	J60188	HB7509	5 (ml/100g)

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James Owens, Quality Assurance Specialist





**Product:** FabCOR Edge XP  
**Diameter:** 1/16"  
**Shielding Gas:** M21-ArC-25  
**Current/Polarity:** DCEP  
**Classification:** E70C-6M H4  
**Specification:** AWS A5.18/A5.18M:2017  
**Test Completed:** 6/19/2024

## Certificate of Conformance

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

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Test Settings	High Heat Input	Low Heat Input	Lot- # J60188	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.1 kJ/in	29.7 kJ/in	<b>Mechanical Properties</b>		78.1 kJ/in	29.7 kJ/in
			Test Reference #		PE8156	PE8163
Voltage	28	28	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	74,700 58,500 33 87	81,000 67,300 28 86
Current (amps)	350	275				
WFS (ipm)	275	200				
Travel Speed (ipm)	6.3	15.5				
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				

Test Settings	High Heat Input	Low Heat Input	Lot- # F623171301	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.9 kJ/in	30.5 kJ/in	<b>Mechanical Properties</b>		79.9 kJ/in	30.5 kJ/in
			Test Reference #		PE2346	PE2352
Voltage	28	26.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	71,200 57,900 33 65	81,400 68,600 26 74
Current (amps)	350	275				
WFS (ipm)	265	195				
Travel Speed (ipm)	7.37	14.35				
Stick Out	3/4"	3/4"				
# of passes	7	18				
# 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- # F62351	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.8 kJ/in	29.8 kJ/in	<b>Mechanical Properties</b>		81.8 kJ/in	29.8 kJ/in
			Test Reference #		PE2381	PE2388
Voltage	28	26.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	71,200 58,100 33 98	80,700 69,600 26 71
Current (amps)	350	285				
WFS (ipm)	255	191				
Travel Speed (ipm)	7.2	14.73				
Stick Out	7/8"	3/4"				
# of passes	7	17				
# 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	J60188	HB7471	4 (ml/100g)
7 Day Exposure	J60188	HB7508	2 (ml/100g)

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