



**Product:** SubCOR 92-S  
**Diameter:** 5/32"  
**Shielding Gas:** HN-590 Flux  
**Current/Polarity:** DCEP  
**Classification:** ECM1; F8A8-ECM1-M1 H8  
**Specification:** AWS A5.23/A5.23M:2011  
**Test Completed:** 6/30/2021

## 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-# F000982311	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	83.2 kJ/in	45.9 kJ/in	Mechanical Properties		83.2 kJ/in	45.9 kJ/in
			Test Reference #		PE2607	PE2603
Voltage	37	27	Tensile Strength (psi)	80,000	89,000	98,100
Current (amps)	750	425	Yield Strength (psi)	68,000	73,500	90,600
WFS (ipm)	95	45	Elongation (%)	19	25	23
Travel Speed (ipm)	20	15	Average Charpy V-notch			
Stick Out	1 1/4"	1 1/4"	Impact Properties ft•lbs @	40	116	95
# of passes	12	19	+70 °F			
# of layers	6	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-# B001782313611	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	83.2 kJ/in	45.9 kJ/in	Mechanical Properties		83.2 kJ/in	45.9 kJ/in
			Test Reference #		PD6336	PD6335
Voltage	37	27	Tensile Strength (psi)	80,000	86,000	97,900
Current (amps)	750	425	Yield Strength (psi)	68,000	71,900	90,900
WFS (ipm)	95	45	Elongation (%)	19	27	22
Travel Speed (ipm)	20	15	Average Charpy V-notch			
Stick Out	1 1/4"	1 1/4"	Impact Properties ft•lbs @	40	119	84
# of passes	11	19	+70 °F			
# of layers	6	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-# R817572301611	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	83.3 kJ/in	45.9 kJ/in	Mechanical Properties		83.3 kJ/in	45.9 kJ/in
			Test Reference #		PC7170	PC7231
Voltage	37	27	Tensile Strength (psi)	80,000	90,000	102,000
Current (amps)	750	425	Yield Strength (psi)	68,000	68,000	95,000
WFS (ipm)	95	45	Elongation (%)	19	26	23
Travel Speed (ipm)	20	15	Average Charpy V-notch			
Stick Out	1 1/4"	1 1/4"	Impact Properties ft•lbs @	40	99	81
# of passes	13	20	+70 °F			
# of layers	6	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 A5.23/A5.23M, Clause 14  
& Extended Exposure - in accordance with AWS D1.8/D1.8M**

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	F000982311	HB4917	4.0 (ml/100g)
7 Day Exposure	F000982311	HB4944	4.2 (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. Please refer to the Hobart Brothers website at [www.hobartbrothers.com](http://www.hobartbrothers.com) for current Safety Data Sheets.

David A. Thomas, Quality Specialist