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	Mechanical Properties		78.8 kJ/in	27.8 kJ/in
Voltage	27	25.5	Test Reference #		PE2254	PE2257
Current (amps)	350	280				
WFS (ipm)	575	385				
Travel Speed (ipm)	7.2	15.4	Tensile Strength (psi)	70,000	81,000	88,600
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	65,900	77,400
# of passes	8	16	Elongation (%)	22	27	26
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	97	92
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		81.1 kJ/in	29.8 kJ/in
Voltage	27	25.5	Test Reference #		PE2212	PE2210
Current (amps)	350	280				
WFS (ipm)	560	385				
Travel Speed (ipm)	7.0	14.44	Tensile Strength (psi)	70,000	77,600	84,500
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	60,800	72,500
# of passes	6	16	Elongation (%)	22	30	28
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	80	68
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		79.5 kJ/in	27.4 kJ/in
Voltage	28	28	Test Reference #		PE8132	PE2195
Current (amps)	300	265				
WFS (ipm)	425	380				
Travel Speed (ipm)	6.3	16.2	Tensile Strength (psi)	70,000	77,700	90,400
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	60,000	80,200
# of passes	7	18	Elongation (%)	22	31	25
# of layers	4	7	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	98	76
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		81.6 kJ/in	27.5 kJ/in
Voltage	28	26	Test Reference #		PE2252	PE2261
Current (amps)	340	270				
WFS (ipm)	560	400				
Travel Speed (ipm)	7.0	15.3	Tensile Strength (psi)	70,000	79,100	85,500
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	62,600	74,100
# of passes	8	16	Elongation (%)	22	29	26
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	88	78
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		82.5 kJ/in	29.2 kJ/in
Voltage	28	26	Test Reference #		PE2211	PE2209
Current (amps)	350	275				
WFS (ipm)	560	370				
Travel Speed (ipm)	7.14	14.83	Tensile Strength (psi)	70,000	76,300	82,200
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	59,900	71,500
# of passes	6	18	Elongation (%)	22	29	27
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	71	54
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		81.75 kJ/in	28.4 kJ/in
Voltage	29	29	Test Reference #		PE7889	PE8118
Current (amps)	300	265				
WFS (ipm)	425	380				
Travel Speed (ipm)	6.4	16.2	Tensile Strength (psi)	70,000	73,800	87,100
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	59,500	74,800
# of passes	7	18	Elongation (%)	22	32	25
# of layers	4	7	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	90	76
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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: .045”
Shielding Gas: Ozoline C8
Current/Polarity: DCEP
Classification: E70C-6M H4
Specification: AWS A5.18/A5.18M:2025
Test Completed: 7/23/2026

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

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Test Settings	High Heat Input	Low Heat Input	Lot- # L91448	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.0 kJ/in	28.0 kJ/in	Mechanical Properties		80.0 kJ/in	28.0 kJ/in
Voltage	28	27	Test Reference #		PF3065	PF3064
Current (amps)	300	275				
WFS (ipm)	425	380				
Travel Speed (ipm)	6.3	15.9	Tensile Strength (psi)	70,000	79,900	91,000
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	62,900	80,600
# of passes	7	18	Elongation (%)	22	31	26
# of layers	4	7	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	96	86
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # L91475	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.8 kJ/in	28.5 kJ/in	Mechanical Properties		78.8 kJ/in	28.5 kJ/in
Voltage	28	27	Test Reference #		PF3071	PF3072
Current (amps)	305	275				
WFS (ipm)	425	380				
Travel Speed (ipm)	7.0	15.6	Tensile Strength (psi)	70,000	79,600	92,100
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	63,800	81,500
# of passes	7	18	Elongation (%)	22	30	25
# of layers	4	7	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	112	79
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # L91881	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.0 kJ/in	27.5 kJ/in	Mechanical Properties		80.0kJ/in	27.5 kJ/in
Voltage	28	27	Test Reference #		PF3080	PF3079
Current (amps)	300	270				
WFS (ipm)	425	380				
Travel Speed (ipm)	6.3	15.9	Tensile Strength (psi)	70,000	79,600	90,300
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	63,200	78,100
# of passes	7	18	Elongation (%)	22	31	26
# of layers	4	7	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	105	79
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	L91448	HB9349	2 (ml/100g)
7 Day Exposure	L91448	HB9360	2 (ml/100g)

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James Owens, Compliance 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

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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	Mechanical Properties		80.4 kJ/in	28.2 kJ/in
Voltage	29.5	26	Test Reference #		PE2262	PE2253
Current (amps)	350	275				
WFS (ipm)	415	265				
Travel Speed (ipm)	7.7	15.2	Tensile Strength (psi)	70,000	75,900	83,300
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	59,800	71,800
# of passes	6	16	Elongation (%)	22	31	26
# of layers	3	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	103	76
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		79.3 kJ/in	29.4 kJ/in
Voltage	27	25	Test Reference #		PE2229	PE2227
Current (amps)	375	275				
WFS (ipm)	420	270				
Travel Speed (ipm)	7.68	14.1	Tensile Strength (psi)	70,000	76,100	85,700
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	61,500	75,100
# of passes	7	17	Elongation (%)	22	33	26
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	107	82
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		79.1 kJ/in	27.9 kJ/in
Voltage	27	26	Test Reference #		PE8190	PE8182
Current (amps)	375	275				
WFS (ipm)	415	275				
Travel Speed (ipm)	7.85	15.3	Tensile Strength (psi)	70,000	79,500	88,100
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	63,800	77,300
# of passes	7	18	Elongation (%)	22	31	27
# of layers	4	7	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	77	48
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		80.2 kJ/in	29.6 kJ/in
Voltage	27.5	25.5	Test Reference #		PE2286	PE2287
Current (amps)	375	275				
WFS (ipm)	420	270				
Travel Speed (ipm)	7.72	14.34	Tensile Strength (psi)	70,000	72,500	80,400
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	58,500	68,600
# of passes	7	18	Elongation (%)	22	32	27
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	84	64
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		80.0 kJ/in	29.2 kJ/in
Voltage	27.5	25.5	Test Reference #		PE2276	PE2275
Current (amps)	375	275				
WFS (ipm)	420	275				
Travel Speed (ipm)	7.74	14.47	Tensile Strength (psi)	70,000	75,200	82,600
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	59,500	70,700
# of passes	7	18	Elongation (%)	22	30	27
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	95	81
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		79.5 kJ/in	30 kJ/in
Voltage	28	27	Test Reference #		PE8194	PE8196
Current (amps)	350	275				
WFS (ipm)	420	275				
Travel Speed (ipm)	7.1	14.8	Tensile Strength (psi)	70,000	78,200	85,000
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	61,700	73,400
# of passes	6	18	Elongation (%)	22	31	28
# of layers	4	7	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	87	75
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		81.2 kJ/in	29.5 kJ/in
Voltage	29.5	27	Test Reference #		PE2228	PE2226
Current (amps)	350	275				
WFS (ipm)	410	270				
Travel Speed (ipm)	7.65	15.2	Tensile Strength (psi)	70,000	71,800	82,900
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	57,600	72,300
# of passes	7	17	Elongation (%)	22	32	26
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	102	71
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		78.4 kJ/in	28.7 kJ/in
Voltage	29.5	27	Test Reference #		PE2200	PE2198
Current (amps)	350	275				
WFS (ipm)	410	265				
Travel Speed (ipm)	7.9	15.5	Tensile Strength (psi)	70,000	72,600	81,200
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	58,100	69,800
# of passes	6	17	Elongation (%)	22	31	26
# of layers	3	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	81	51
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		81.5 kJ/in	29.4 kJ/in
Voltage	29	27	Test Reference #		PE8209	PE8220
Current (amps)	350	275				
WFS (ipm)	425	265				
Travel Speed (ipm)	7.4	14.72	Tensile Strength (psi)	70,000	76,700	82,800
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	60,900	69,800
# of passes	6	17	Elongation (%)	22	30	29
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	91	74
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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

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- # F64777	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	77.3 kJ/in	29.5 kJ/in	Mechanical Properties		77.3 kJ/in	29.5 kJ/in
Voltage	29	26	Test Reference #		PE3175	PE3176
Current (amps)	350	300				
WFS (ipm)	410	300				
Travel Speed (ipm)	7.89	15.91	Tensile Strength (psi)	70,000	73,000	85,000
Stick Out	1”	3/4”	Yield Strength (psi)	58,000	58,000	74,000
# of passes	7	15	Elongation (%)	22	30	26
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	56	68
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		78.5 kJ/in	29.7 kJ/in
Voltage	29	26	Test Reference #		PE3189	PE3190
Current (amps)	350	300				
WFS (ipm)	410	300				
Travel Speed (ipm)	7.92	15.83	Tensile Strength (psi)	70,000	76,000	88,000
Stick Out	1”	1”	Yield Strength (psi)	58,000	60,000	77,000
# of passes	7	15	Elongation (%)	22	33	26
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	65	88
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		78.7 kJ/in	30.9 kJ/in
Voltage	28	26	Test Reference #		PE8226	PE8227
Current (amps)	350	300				
WFS (ipm)	410	340				
Travel Speed (ipm)	7.4	15.1	Tensile Strength (psi)	70,000	80,400	88,300
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	64,100	75,200
# of passes	7	15	Elongation (%)	22	31	26
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	77	80
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		79.7 kJ/in	31.4 kJ/in
Voltage	26	26	Test Reference #		PE8170	PE8169
Current (amps)	375	300				
WFS (ipm)	295	220				
Travel Speed (ipm)	7.3	14.9	Tensile Strength (psi)	70,000	78,200	86,400
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	61,100	75,100
# of passes	7	16	Elongation (%)	22	32	27
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	97	84
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		80.3 kJ/in	30.8 kJ/in
Voltage	26.5	30	Test Reference #		PE2339	PE2299
Current (amps)	375	350				
WFS (ipm)	295	200				
Travel Speed (ipm)	7.45	15.0	Tensile Strength (psi)	70,000	73,400	79,400
Stick Out	3/4”	7/8”	Yield Strength (psi)	58,000	58,500	67,000
# of passes	7	16	Elongation (%)	22	31	27
# of layers	4	7	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	80	67
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		81.4 kJ/in	29.8 kJ/in
Voltage	26.5	26	Test Reference #		PE2387	PE2372
Current (amps)	375	300				
WFS (ipm)	295	220				
Travel Speed (ipm)	7.38	15.7	Tensile Strength (psi)	70,000	75,300	85,400
Stick Out	1”	1”	Yield Strength (psi)	58,000	59,800	73,800
# of passes	7	17	Elongation (%)	22	30	27
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	85	79
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		80.3 kJ/in	29.3 kJ/in
Voltage	27	27	Test Reference #		PE8152	PE8147
Current (amps)	350	275				
WFS (ipm)	275	190				
Travel Speed (ipm)	7	14.9	Tensile Strength (psi)	70,000	76,500	82,700
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	60,900	71,400
# of passes	7	18	Elongation (%)	22	34	27
# of layers	4	7	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	94	88
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		80.6 kJ/in	30.6 kJ/in
Voltage	27	26.5	Test Reference #		PE2344	PE2358
Current (amps)	360	285				
WFS (ipm)	275	191				
Travel Speed (ipm)	7.24	14.85	Tensile Strength (psi)	70,000	72,400	78,600
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	58,600	65,700
# of passes	7	17	Elongation (%)	22	32	27
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	74	87
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		78.0 kJ/in	30.3 kJ/in
Voltage	27	26.5	Test Reference #		PE2385	PE2384
Current (amps)	360	285				
WFS (ipm)	275	191				
Travel Speed (ipm)	7.52	15.0	Tensile Strength (psi)	70,000	73,600	80,300
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	59,400	68,900
# of passes	7	17	Elongation (%)	22	30	27
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	77	82
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		78.1 kJ/in	29.7 kJ/in
Voltage	28	28	Test Reference #		PE8156	PE8163
Current (amps)	350	275				
WFS (ipm)	275	200				
Travel Speed (ipm)	6.3	15.5	Tensile Strength (psi)	70,000	74,700	81,000
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	58,500	67,300
# of passes	7	18	Elongation (%)	22	33	28
# of layers	4	7	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	87	86
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		79.9 kJ/in	30.5 kJ/in
Voltage	28	26.5	Test Reference #		PE2346	PE2352
Current (amps)	350	275				
WFS (ipm)	265	195				
Travel Speed (ipm)	7.37	14.35	Tensile Strength (psi)	70,000	71,200	81,400
Stick Out	3/4”	3/4”	Yield Strength (psi)	58,000	57,900	68,600
# of passes	7	18	Elongation (%)	22	33	26
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	65	74
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	Mechanical Properties		81.8 kJ/in	29.8 kJ/in
Voltage	28	26.5	Test Reference #		PE2381	PE2388
Current (amps)	350	285				
WFS (ipm)	255	191				
Travel Speed (ipm)	7.2	14.73	Tensile Strength (psi)	70,000	71,200	80,700
Stick Out	7/8”	3/4”	Yield Strength (psi)	58,000	58,100	69,600
# of passes	7	17	Elongation (%)	22	33	26
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	98	71
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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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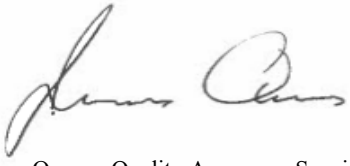

James Owens, Quality Assurance Specialist