



Product: FabCO RXR
Diameter: 1/16"
Shielding Gas: C1 (100% CO2)
Current/Polarity: DCEP
Classification: E70T-1, E70T-9
Specification: AWS A5.20/A5.20M:2005
Test Completed: 8/08/2019

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- # C000671202441	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.1 kJ/in	28.7 kJ/in	Mechanical Properties		79.1 kJ/in	28.7 kJ/in
			Test Reference #		PD8033	PD8041
Voltage	32	28	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	92,100 77,800 27 64	98,700 88,200 23 44
Current (amps)	400	250				
WFS (ipm)	420	210				
Travel Speed (ipm)	9.7	14.6				
Stick Out	3/4"	3/4"				
# of passes	8	20				
# 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- # Z020301601432	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
			Test Reference #		PD1897	PD1961
Voltage	32	28	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	86,800 71,900 29 79	100,000 94,400 23 65
Current (amps)	400	250				
WFS (ipm)	400	210				
Travel Speed (ipm)	9.4	14.3				
Stick Out	3/4"	3/4"				
# of passes	7	23				
# of layers	4	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- # V018271208323	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.3 kJ/in	29.6 kJ/in	Mechanical Properties		81.3 kJ/in	29.6 kJ/in
			Test Reference #		PC0789	PC0802
Voltage	32	28	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	87,300 71,200 28 63	102,000 94,600 23 54
Current (amps)	398	259				
WFS (ipm)	400	208				
Travel Speed (ipm)	9.4	14.7				
Stick Out	3/4"	3/4"				
# of passes	7	21				
# 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 A5.20/A5.20M, Clause 16
& Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	C000671202441	HB3075	3.3 (ml/100g)
7 Day Exposure	C000671202441	HB3173	7.6 (ml/100g)

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David A. Thomas, Quality Assurance Representative



Product: FabCO RXR
Diameter: 3/32"
Shielding Gas: C1 (100% CO2)
Current/Polarity: DCEP
Classification: E70T-1, E70T-9C
Specification: AWS A5.20/A5.20M:2021
Test Completed: 2/24/2022

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

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Test Settings	High Heat Input	Low Heat Input	Lot- # G00091	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	82.5 kJ/in	40.0 kJ/in	Mechanical Properties		82.5 kJ/in	40.0 kJ/in
			Test Reference #		PE3559	PE3603
Voltage	34	28	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 70,000 24 59	95,000 84,000 24 68
Current (amps)	550	350				
WFS (ipm)	240	125				
Travel Speed (ipm)	13.6	14.7				
Stick Out	1"	1"				
# of passes	8	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- # B018031013852	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	84.4 kJ/in	37.8 kJ/in	Mechanical Properties		84.4 kJ/in	37.8 kJ/in
			Test Reference #		PD7170	PD7135
Voltage	34	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	92,000 77,000 27 54	99,000 89,000 24 66
Current (amps)	550	350				
WFS (ipm)	240	125				
Travel Speed (ipm)	13	15				
Stick Out	1"	1"				
# of passes	7	14				
# 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- # Z002191114072	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.1 kJ/in	37.8 kJ/in	Mechanical Properties		80.1 kJ/in	37.8 kJ/in
			Test Reference #		PD0546	PD0535
Voltage	34	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	90,000 74,000 26 70	99,000 92,000 23 60
Current (amps)	550	350				
WFS (ipm)	225	125				
Travel Speed (ipm)	14	15				
Stick Out	1"	1"				
# of passes	8	14				
# 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 A5.20/A5.20M, Clause 16
& Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	G00091	HB5451	5.3 (ml/100g)
7 Day Exposure	G00091	HB5479	7.4 (ml/100g)

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