



**Product:** FabCO Triple 7  
**Diameter:** .045"  
**Shielding Gas:** C1 (100% CO2)  
**Current/Polarity:** DCEP  
**Classification:** E71T-1 H8, E71T-9 H8  
**Specification:** AWS A5.20/A5.20M:2005  
**Test Completed:** 8/04/2023

## 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- # C608862501171	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	82.9 kJ/in	28.2 kJ/in	<b>Mechanical Properties</b>		82.9 kJ/in	28.2 kJ/in
			Test Reference #		PD8878	PD8877
Voltage	25	27.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	71,500 61,200 29 169	83,100 77,900 25 92
Current (amps)	220	290				
WFS (ipm)	350	490				
Travel Speed (ipm)	3.99	17				
Stick Out	5/8"	5/8"				
# of passes	7	19				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # H60071	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.7 kJ/in	31.7 kJ/in	<b>Mechanical Properties</b>		81.7 kJ/in	31.7 kJ/in
			Test Reference #		PE6604	PE6602
Voltage	25	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	77,100 67,500 30 134	94,200 89,600 22 69
Current (amps)	220	290				
WFS (ipm)	375	600				
Travel Speed (ipm)	4.0	14.8				
Stick Out	5/8"	5/8"				
# of passes	8	15				
# of layers	4	6				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # D61355	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.3 kJ/in	29.9 kJ/in	<b>Mechanical Properties</b>		80.3 kJ/in	29.9 kJ/in
			Test Reference #		PE1364	PE1362
Voltage	25	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	72,100 62,800 29 139	90,000 84,700 22 104
Current (amps)	225	290				
WFS (ipm)	375	600				
Travel Speed (ipm)	4.22	15.7				
Stick Out	5/8"	3/4"				
# of passes	6	14				
# of layers	4	5				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	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	H60071	HB6999	4.7 (ml/100g)
7 Day Exposure	H60071	HB7040	5.8 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCO Triple 7  
**Diameter:** .045"  
**Shielding Gas:** M21-ArC-25  
**Current/Polarity:** DCEP  
**Classification:** E71T-1 H8, E71T-9 H8  
**Specification:** AWS A5.20/A5.20M:2005  
**Test Completed:** 8/04/2023

## 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- # C608862501171	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	82.5 kJ/in	27.6 kJ/in	Mechanical Properties		82.5 kJ/in	27.6 kJ/in
			Test Reference #		PD8880	PD8879
Voltage	25	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 67,100 28 130	90,500 86,000 23 94
Current (amps)	220	290				
WFS (ipm)	350	490				
Travel Speed (ipm)	4	17				
Stick Out	5/8"	5/8"				
# of passes	7	19				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # H60071	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.8 kJ/in	30.8 kJ/in	Mechanical Properties		78.8 kJ/in	30.8 kJ/in
			Test Reference #		PE6605	PE6606
Voltage	24	27	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 75,300 27 129	101,000 95,000 23 113
Current (amps)	220	300				
WFS (ipm)	375	600				
Travel Speed (ipm)	4.2	15.75				
Stick Out	5/8"	5/8"				
# of passes	8	15				
# of layers	4	6				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # D61355	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.8 kJ/in	29.2 kJ/in	Mechanical Properties		78.8 kJ/in	29.2 kJ/in
			Test Reference #		PE1365	PE1363
Voltage	24.5	27	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 72,400 26 137	99,400 97,000 24 123
Current (amps)	225	290				
WFS (ipm)	375	600				
Travel Speed (ipm)	4.20	16.1				
Stick Out	5/8"	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	3G	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	H60071	HB6998	4.2 (ml/100g)
7 Day Exposure	H60071	HB7041	5.0 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCO Triple 7  
**Diameter:** .052"  
**Shielding Gas:** C1 (100% CO2)  
**Current/Polarity:** DCEP  
**Classification:** E71T-1 H8, E71T-9 H8  
**Specification:** AWS A5.20/A5.20M:2005  
**Test Completed:** 8/04/2023

## Certificate of Conformance

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

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Test Settings	High Heat Input	Low Heat Input	Lot- # H01757	AWS D1.8 Requirements	High Heat Input	Low Heat Input	
	83.3 kJ/in	30.7 kJ/in			83.3 kJ/in	30.7 kJ/in	
			<b>Mechanical Properties</b>				
			Test Reference #		PE6579	PE6576	
Voltage	25	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	77,200	85,700	
Current (amps)	225	270			28	140	160
WFS (ipm)	260	350					
Travel Speed (ipm)	4	13.6					
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	3G	1G					

Test Settings	High Heat Input	Low Heat Input	Lot- # D61355	AWS D1.8 Requirements	High Heat Input	Low Heat Input	
	81.7 kJ/in	29.9 kJ/in			81.7 kJ/in	29.9 kJ/in	
			<b>Mechanical Properties</b>				
			Test Reference #		PE1321	PE1320	
Voltage	25.5	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	74,900	87,700	
Current (amps)	230	275			32	112	128
WFS (ipm)	270	350					
Travel Speed (ipm)	4.32	14.35					
Stick Out	5/8"	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	3G	1G					

Test Settings	High Heat Input	Low Heat Input	Lot- # D61354	AWS D1.8 Requirements	High Heat Input	Low Heat Input	
	80.2 kJ/in	29.9 kJ/in			80.2 kJ/in	29.9 kJ/in	
			<b>Mechanical Properties</b>				
			Test Reference #		PE1349	PE1347	
Voltage	25.5	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	74,900	86,300	
Current (amps)	225	275			29	174	124
WFS (ipm)	260	350					
Travel Speed (ipm)	4.3	14.35					
Stick Out	5/8"	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	3G	1/G					

**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	H01757	HB7000	4.6 (ml/100g)
7 Day Exposure	H01757	HB7043	8.4 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCO Triple 7  
**Diameter:** .052"  
**Shielding Gas:** M21-ArC-25  
**Current/Polarity:** DCEP  
**Classification:** E71T-1 H8, E71T-9 H8  
**Specification:** AWS A5.20/A5.20M:2005  
**Test Completed:** 8/04/2023

## Certificate of Conformance

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

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Test Settings	High Heat Input	Low Heat Input	Lot- # H01757	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.2 kJ/in	30.7 kJ/in			81.2 kJ/in	30.7 kJ/in
			<b>Mechanical Properties</b>			
			Test Reference #		PE6569	PE6573
Voltage	24	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	86,400 74,200 28 171	99,300 94,400 23 143
Current (amps)	225	275				
WFS (ipm)	255	367				
Travel Speed (ipm)	4.0	13.4				
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	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # D61355	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	82.7 kJ/in	29.0 kJ/in			82.7 kJ/in	29.0 kJ/in
			<b>Mechanical Properties</b>			
			Test Reference #		PE1319	PE1318
Voltage	24	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	83,100 69,400 29 122	100,000 96,300 22 135
Current (amps)	230	275				
WFS (ipm)	270	367				
Travel Speed (ipm)	4.05	14.24				
Stick Out	5/8"	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	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # D61354	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.7 kJ/in	30.0 kJ/in			79.7 kJ/in	30.0 kJ/in
			<b>Mechanical Properties</b>			
			Test Reference #		PE1350	PE1348
Voltage	24.5	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	80,800 68,400 30 130	99,000 93,600 23 117
Current (amps)	225	275				
WFS (ipm)	255	350				
Travel Speed (ipm)	4.2	13.75				
Stick Out	5/8"	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	3G	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	H01757	HB7001	5.1 (ml/100g)
7 Day Exposure	H01757	HB7042	8.2 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCO Triple 7  
**Diameter:** 1/16"  
**Shielding Gas:** C1 (100% CO2)  
**Current/Polarity:** DCEP  
**Classification:** E71T-1 H8, E71T-9 H8  
**Specification:** AWS A5.20/A5.20M:2005  
**Test Completed:** 07/31/2023

## Certificate of Conformance

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

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Test Settings	High Heat Input	Low Heat Input	Lot- # G64695	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.1 kJ/in	30.5 kJ/in	<b>Mechanical Properties</b>		78.1 kJ/in	30.5 kJ/in
			Test Reference #		PE6464	PE6471
Voltage	25	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	78,300 70,700 30 218	84,500 80,000 25 143
Current (amps)	225	260				
WFS (ipm)	180	240				
Travel Speed (ipm)	4.1	13.7				
Stick Out	3/4"	3/4"				
# of passes	8	17				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # D61280	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	82.4 kJ/in	28.7 kJ/in	<b>Mechanical Properties</b>		82.4 kJ/in	28.7 kJ/in
			Test Reference #		PE1257	PE1256
Voltage	25	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	72,900 63,000 32 96	82,700 77,900 26 87
Current (amps)	220	260				
WFS (ipm)	185	215				
Travel Speed (ipm)	4.01	14.18				
Stick Out	3/4"	3/4"				
# of passes	6	19				
# of layers	3	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # D61354	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.7 kJ/in	29.0 kJ/in	<b>Mechanical Properties</b>		81.7 kJ/in	29.0 kJ/in
			Test Reference #		PE1287	PE1286
Voltage	25	26	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 67,300 28 74	85,800 81,100 27 145
Current (amps)	225	260				
WFS (ipm)	185	215				
Travel Speed (ipm)	4.13	14.04				
Stick Out	3/4"	3/4"				
# of passes	6	19				
# of layers	3	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	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	G64695	HB6960	4.8 (ml/100g)
7 Day Exposure	G64695	HB7019	5.6 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCO Triple 7  
**Diameter:** 1/16"  
**Shielding Gas:** M20-ArC-15  
**Current/Polarity:** DCEP  
**Classification:** E71T-1 H8, E71T-9 H8  
**Specification:** AWS A5.20/A5.20M:2021  
**Test Completed:** 02/16/2026

## Certificate of Conformance

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

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Test Settings	High Heat Input	Low Heat Input	Lot- # K63497	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.0 kJ/in	31.8 kJ/in			79.0 kJ/in	31.8 kJ/in
			<b>Mechanical Properties</b>			
			Test Reference #		PF2043	PF2042
Voltage	24	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	89,700	94,700
Current (amps)	225	265			26	87,700
WFS (ipm)	180	205			23	
Travel Speed (ipm)	4.1	12.5				
Stick Out	3/4"	3/4"				
# of passes	8	19				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # K63522	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.7 kJ/in	31.8 kJ/in			80.7 kJ/in	31.8 kJ/in
			<b>Mechanical Properties</b>			
			Test Reference #		PF2078	PF2079
Voltage	24	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	90,300	94,000
Current (amps)	225	265			27	87,800
WFS (ipm)	180	205			24	
Travel Speed (ipm)	4.1	12.5				
Stick Out	3/4"	3/4"				
# of passes	8	18				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # K63756	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.0 kJ/in	29.7 kJ/in			79.0 kJ/in	29.7 kJ/in
			<b>Mechanical Properties</b>			
			Test Reference #		PF2103	PF1931
Voltage	24	23.5	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	89,200	95,600
Current (amps)	225	260			29	89,000
WFS (ipm)	180	205			24	
Travel Speed (ipm)	4.1	12				
Stick Out	3/4"	3/4"				
# of passes	8	18				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	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	K63756	HB8924	5 (ml/100g)
7 Day Exposure	K63756	HB8923	8 (ml/100g)

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James Owens, Quality Assurance Specialist



**Product:** FabCO Triple 7  
**Diameter:** 1/16"  
**Shielding Gas:** M21-ArC-25  
**Current/Polarity:** DCEP  
**Classification:** E71T-1 H8, E71T-9 H8  
**Specification:** AWS A5.20/A5.20M:2005  
**Test Completed:** 07/31/2023

## 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- # G64695	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	78.7 kJ/in	29.8 kJ/in	<b>Mechanical Properties</b>		78.7 kJ/in	29.8 kJ/in
			Test Reference #		PE6453	PE6454
Voltage	24	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	82,600 71,300 28 149	94,100 91,100 27 153
Current (amps)	225	280				
WFS (ipm)	180	240				
Travel Speed (ipm)	4.1	14				
Stick Out	3/4"	3/4"				
# of passes	8	17				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # D61280	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.8 kJ/in	29.8 kJ/in	<b>Mechanical Properties</b>		80.8 kJ/in	29.8 kJ/in
			Test Reference #		PE1247	PE1246
Voltage	24.5	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	77,500 67,300 32 136	86,900 82,900 29 158
Current (amps)	225	260				
WFS (ipm)	185	215				
Travel Speed (ipm)	4.10	13.64				
Stick Out	3/4"	3/4"				
# of passes	6	19				
# of layers	3	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # D61354	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	83.0 kJ/in	29.2 kJ/in	<b>Mechanical Properties</b>		83.0 kJ/in	29.2 kJ/in
			Test Reference #		PE1285	PE1284
Voltage	24	26	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	81,300 67,200 28 121	94,000 89,500 25 143
Current (amps)	225	260				
WFS (ipm)	185	218				
Travel Speed (ipm)	3.91	13.93				
Stick Out	3/4"	3/4"				
# of passes	6	19				
# of layers	3	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	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	G64695	HB6959	6.6 (ml/100g)
7 Day Exposure	G64695	HB7018	5.5 (ml/100g)

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