



**Product:** FabCO XL-525  
**Diameter:** .052"  
**Shielding Gas:** M21-ArC-25  
**Current/Polarity:** DCEP  
**Classification:** E71T-1M; E71T-12MJ H8  
**Specification:** AWS A5.20/A5.20M:2005  
**Test Completed:** 2/20/2020

## 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 ISO9001:2015, ANSI/AWS A5.01, and other specification and Military requirements, as applicable.

Test Settings	High Heat Input	Low Heat Input	Lot- # D000032205711	AWS D1.8 Requirements	High Heat Input	Low Heat Input									
	83.9 kJ/in	29.1 kJ/in	Mechanical Properties		80.5 kJ/in	29.1 kJ/in									
			Test Reference #		PD9135	PD9151									
Voltage	25	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000	74,000	81,000									
Current (amps)	220	250					58,000	66,000	75,000						
WFS (ipm)	230	290								22	30	26			
Travel Speed (ipm)	4.1	13.9											40	166	127
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	3G	1G													

Test Settings	High Heat Input	Low Heat Input	Lot- # A003812308003	AWS D1.8 Requirements	High Heat Input	Low Heat Input									
	83.9 kJ/in	27.0 kJ/in	Mechanical Properties		83.9 kJ/in	27.0 kJ/in									
			Test Reference #		PD3279	PD3278									
Voltage	26	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000	76,000	83,000									
Current (amps)	250	250					58,000	65,000	77,000						
WFS (ipm)	325	290								22	30	25			
Travel Speed (ipm)	4.2	15											40	183	127
Stick Out	3/4"	3/4"													
# of passes	7	20													
# 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- # V029232605452	AWS D1.8 Requirements	High Heat Input	Low Heat Input									
	81.0 kJ/in	26.1 kJ/in	Mechanical Properties		81.0 kJ/in	26.1 kJ/in									
			Test Reference #		PC3552	PC3312									
Voltage	23.5	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000	74,000	81,000									
Current (amps)	220	250					58,000	63,000	77,000						
WFS (ipm)	245	315								22	31	26			
Travel Speed (ipm)	3.8	15.5											40	131	142
Stick Out	5/8"	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	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	D000032205711	HB3968	3.0 (ml/100g)
7 Day Exposure	D000032205711	HB3989	3.7 (ml/100g)

The information contained or otherwise referenced herein is presented without guarantee or warranty. Hobart Brothers Company ("Hobart") 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. **Hobart produces welding consumables under continuing quality assurance programs audited and approved by the American Bureau of Shipping ("ABS").** Please refer to the Hobart Brothers Company website at [www.hobartbrothers.com](http://www.hobartbrothers.com) for current Safety Data Sheets ("SDS").

David A. Thomas, Quality Assurance Representative