



**Product:** Fabshield XLNT-6  
**Diameter:** 3/32"  
**Shielding Gas:** N/A  
**Current/Polarity:** DCEP  
**Classification:** AWS E70T-6  
**Specification:** AWS A5.20/A5.20M:2005  
**Test Completed:** 4/10/2019

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

Test Settings	High Heat Input	Low Heat Input	Lot- # C001421501313	AWS D1.8 Requirements	High Heat Input	Low Heat Input	
	73.5 kJ/in	42.8 kJ/in	Mechanical Properties		73.5 kJ/in	42.8 kJ/in	
			Test Reference #		PD7586	PD7473	
Voltage	26	25	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	77,000	93,000	
Current (amps)	445	310			58,000	77,000	77,000
WFS (ipm)	260	125			22	28	22
Travel Speed (ipm)	9.4	10.87			40	51	42
Stick Out	1"	1"					
# of passes	6	13					
# 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- # Z006572402502	AWS D1.8 Requirements	High Heat Input	Low Heat Input	
	70.8 kJ/in	41.3 kJ/in	Mechanical Properties		70.8 kJ/in	41.3 kJ/in	
			Test Reference #		PD0962	PD1068	
Voltage	26	22	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	80,000	94,000	
Current (amps)	443	322			59,000	75,000	75,000
WFS (ipm)	260	140			24	24	24
Travel Speed (ipm)	9.75	11.68			47	45	45
Stick Out	1"	1"					
# of passes	7	12					
# of layers	4	5					
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- # T001632409503	AWS D1.8 Requirements	High Heat Input	Low Heat Input	
	77.1 kJ/in	38.8 kJ/in	Mechanical Properties		68.2 kJ/in	38.8 kJ/in	
			Test Reference #		PB7773	PB7820	
Voltage	26	22	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	80,000	91,000	
Current (amps)	450	320			58,000	75,000	75,000
WFS (ipm)	260	125			26	22	22
Travel Speed (ipm)	9.1	10.9			51	45	45
Stick Out	1 1/4"	1 1/4"					
# of passes	7	18					
# 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	C001421501313	HB3073	5.8 (ml/100g)
7 Day Exposure	C001421501313	HB3177	7.6 (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").

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