Product: SubCOR 92-S
Diameter: 5/32”
Shielding Gas: HN-590 Flux
Current/Polarity: DCEP
Classification: ECM1; F8A8-ECM1-M1 H8
Specification: AWS A5.23/A5.23M:2011
Test Completed: 3/01/2024

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- # F000982311	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	83.2 kJ/in	45.9 kJ/in	Mechanical Properties		83.2 kJ/in	45.9 kJ/in
Voltage	37	27	Test Reference #		PE2607	PE2603
Current (amps)	750	425				
WFS (ipm)	95	45				
Travel Speed (ipm)	20	15	Tensile Strength (psi)	80,000	89,000	98,100
Stick Out	1 1/4”	1 1/4”	Yield Strength (psi)	68,000	73,500	90,600
# of passes	12	19	Elongation (%)	19	25	23
# of layers	6	8	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	116	95
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # B001782313611	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	83.2 kJ/in	45.9 kJ/in	Mechanical Properties		83.2 kJ/in	45.9 kJ/in
Voltage	37	27	Test Reference #		PD6336	PD6335
Current (amps)	750	425				
WFS (ipm)	95	45				
Travel Speed (ipm)	20	15	Tensile Strength (psi)	80,000	86,000	97,900
Stick Out	1 1/4”	1 1/4”	Yield Strength (psi)	68,000	71,900	90,900
# of passes	11	19	Elongation (%)	19	27	22
# of layers	6	7	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	119	84
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # H03913	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.1 kJ/in	41.0 kJ/in	Mechanical Properties		80.1 kJ/in	41.0 kJ/in
Voltage	37	27	Test Reference #		PE7609	PE7603
Current (amps)	475	425				
WFS (ipm)	100	54				
Travel Speed (ipm)	20.7	16.7	Tensile Strength (psi)	80,000	93,000	93,600
Stick Out	1 1/4”	1 1/4”	Yield Strength (psi)	68,000	80,500	84,900
# of passes	15	21	Elongation (%)	19	24	24
# of layers	7	9	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	104	87
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
Weld Position	1G	1G				

Diffusible Hydrogen - Tested in accordance with AWS A5.23/A5.23M, Clause 14 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	H03913	HB7456	3 (ml/100g)
7 Day Exposure	H03913	HB7475	3 (ml/100g)

The information contained or otherwise referenced herein is presented without guarantee or warranty. Hobart Brothers LLC 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 Brothers. Refer to the Hobart Brothers website at www.hobartbrothers.com for current Safety Data Sheets ("SDS").

James Owens, Quality Assurance Specialist