

Diameter: .045

AWS D1.8 Seismic Certificate of Conformance

This is to certify that the product stated below is of the same classification, manufacturing process, and material requirements as the electrode used for the testing on the date stated. All tests required by the specifications for classification were performed and the material met all requirements. It was manufactured and supplied according to the quality management system of Select-Arc, Inc., which meets the requirements of ISO 9001 and other applicable specifications. This certificate complies with the requirements of EN 10204, Type 2.2.

Product: Select 70C-6	Test Completion Date: 3/9/2020
Diameter(s): .045	Lot Numbers: (.045) 2933 2998 3966
Lot Class: 'T4' per AWS A5.01	Certificate Expiration Date: 3/9/2023
Specifications: AWS D1.8: 2016	
Classification: E70C-6M	

Weld Parameters - High Heat Input

Lot Number:	2933	2998	3966
Electrode Diameter:	.045	.045	.045
Shielding Gas	85%Ar / 15%CO2	85%Ar / 15%CO2	85%Ar / 15%CO2
Amperage:	273.0	272.0	263.0
Arc Voltage:	28.0	28.0	28.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	3/4"	3/4"	3/4"
No. of Passes/Layers:	8/5	8/5	8/5
Interpass Temperature(°F):	450	450	450
Heat Input Avg.(kj/in.):	67.2	65.8	68.4

Mechanical Properties - High Heat Input

Lot Number:		2933	2998	3966
Shielding Gas		85%Ar / 15%CO2	85%Ar / 15%CO2	85%Ar / 15%CO2
Requirements		Results	Results	Results
Test Condition:	As-Welded	As-Welded	As-Welded	As-Welded
PWHT Temperature:	-	-	-	-
Tensile Strength (psi):	70000 min	78000	80000	80000
Yield Strength (psi):	58000 min	60000	63000	63000
Elongation (%):	22 min	32	33	31
Charpy V-Notch Impacts:		89, 86, 96	67, 58, 64	94, 85, 84
	ft-lb f @ 70°F	40 avg.	90 avg	63 avg
			88 avg	

Weld Parameters - Low Heat Input

Lot Number:	2933	2998	3966
Electrode Diameter:	.045	.045	.045
Shielding Gas	85%Ar / 15%CO2	85%Ar / 15%CO2	85%Ar / 15%CO2
Amperage:	230.0	231.0	228.0
Arc Voltage:	27.0	27.0	27.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	3/4"	3/4"	3/4"
No. of Passes/Layers:	18/9	18/9	18/9
Interpass Temperature(°F):	250	250	250
Heat Input Avg.(kj/in.):	27.8	28.4	27.8

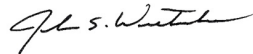
Mechanical Properties - Low Heat Input

Lot Number:		2933	2998	3966
Shielding Gas		85%Ar / 15%CO2	85%Ar / 15%CO2	85%Ar / 15%CO2
Requirements		Results	Results	Results
Test Condition:	As-Welded	As-Welded	As-Welded	As-Welded
PWHT Temperature:	-	-	-	-
Tensile Strength (psi):	70000 min	81000	83000	84000
Yield Strength (psi):	58000 min	69000	71000	73000
Elongation (%):	22 min	30	30	30
Charpy V-Notch Impacts:		125, 126, 129	107, 107, 106	108, 110, 120
	ft-lb f @ 70°F	40 avg.	127 avg	107 avg
			113 avg	

This product meets the requirements for a 2 week exposure at 80°F, 80% humidity (per Annex E of AWS D1.8:2016)

The undersigned certifies that the product supplied will meet the requirements of the applicable AWS Filler Metal Specification when tested in accordance with that specification.

Signed By: _____



Joshua S Westerheide, Quality Manager