

Diameter: 1/16

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: 5/14/2020

Diameter(s): 1/16

Lot Numbers: (1/16) 3861 4050 6415

Lot Class: 'T4' per AWS A5.01

Certificate Expiration Date: 5/14/2023

Specifications: AWS D1.8: 2016

Classification: E70C-6M

Weld Parameters - High Heat Input

Lot Number:	3861	4050	6415
Electrode Diameter:	1/16	1/16	1/16
Shielding Gas	85%Ar / 15%CO2	85%Ar / 15%CO2	85%Ar / 15%CO2
Amperage:	363.0	366.0	334.0
Arc Voltage:	29.0	29.0	29.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	1	1	1
No. of Passes/Layers:	8/5	8/5	8/5
Interpass Temperature(°F):	450	450	450
Heat Input Avg.(kj/in.):	70.9	71.6	69.9

Weld Parameters - Low Heat Input

Lot Number:	3861	4050	6415
Electrode Diameter:	1/16	1/16	1/16
Shielding Gas	85%Ar / 15%CO2	85%Ar / 15%CO2	85%Ar / 15%CO2
Amperage:	314.0	311.0	315.0
Arc Voltage:	27.0	27.0	27.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	1	1	1
No. of Passes/Layers:	18/9	18/9	17/8
Interpass Temperature(°F):	250	250	250
Heat Input Avg.(kj/in.):	29.5	28.5	28.5

Mechanical Properties - High Heat Input

Lot Number:		3861	4050	6415
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	79000	84000	77000
Yield Strength (psi):	58000 min	62000	68000	60000
Elongation (%):	22 min	30	30	33
Charpy V-Notch Impacts:		135, 136, 131	95, 89, 100	131, 137, 129
	ft-lb f @ 70°F	40 avg.	134 avg	95 avg

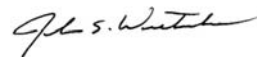
Mechanical Properties - Low Heat Input

Lot Number:		3861	4050	6415
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	84000	89000	85000
Yield Strength (psi):	58000 min	71000	78000	73000
Elongation (%):	22 min	28	29	29
Charpy V-Notch Impacts:		146, 146, 152	132, 139, 140	142, 139, 152
	ft-lb f @ 70°F	40 avg.	148 avg	137 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