# AWS D1.8 SEISMIC CERTIFICATION OF CONFORMANCE

Manufactured in the U.S.A. by :

SELECT-ARC, INC.
600 Enterprise Dr.
P. O. Box 259
Fort Loramie, OH 45845

Supplied to :

Date:
Customer Order Number:
Order Number:
Lot/ Production No. Shipped:

Lot/ Production No. Tested: **3654**A404A1014
Test No: 15089-7, 15089-17

This is to certify that **Select 720** electrode, classification **E71T-1C, -9C, -12C** as supplied on the above order number, is of the same classification, manufacturing process and material requirements as the electrode used for testing. All tests required by specifications **AWS D1.8/D1.8M:2009**, for wire diameter **.052" and 100% CO2 Shielding Gas**, were performed in conformance with these specifications and the results met all requirements. The test results were as follows:

**MECHANICAL PROPERTIES** AS WELDED ☒ STRESS RELIEVED ( hr @ °F) ☐

**WELDING PARAMETERS:**

HIGH HEAT INPUT:
Amperage: 193
Arc Voltage: 26.0
Current Polarity: DCEP
Electrical Extension (in): 3/4
Shielding Gas: 100CO2
No. of Passes/Layers: 7/5
Preheat Temp (°F): 250 min.
Interpass Temp (°F): 450 min.
Heat Input Avg (kJ/in): 81
Travel Speed (ipm): 3.7

LOW HEAT INPUT:
Amperage: 184
Arc Voltage: 25
Current Polarity: DCEP
Electrical Extension (in): 3/4
Shielding Gas: 100CO2
No. of Passes/Layers: 16/8
Preheat Temp (°F): 120 max.
Interpass Temp (°F): 250 max
Heat Input Avg (kJ/in): 30
Travel Speed (ipm): 9.3

**TEST RESULTS:**

| HIGH HEAT INPUT: | REQUIREMENTS: | RESULTS: |
|---|---|---|
| Tensile Strength (psi): | 70,000 min | 72,500 |
| Yield Strength (psi): | 58,000 min | 58,900 |
| Elongation (%): | 22 min | 36 |
| Avg Charpy Impact: ft•lb *f* @ 70°F: | 40 min | 205, 198, 214<br>206 avg. |
| Avg Charpy Impact: ft•lb *f* @ 32°F: | 40 min | 140, 150, 161<br>150 avg. |

| LOW HEAT INPUT: | REQUIREMENTS: | RESULTS: |
|---|---|---|
| Tensile Strength (psi): | 70,000 min | 87,500 |
| Yield Strength (psi): | 58,000 min | 79,800 |
| Elongation (%): | 22 min | 30 |
| Avg Charpy Impact: ft•lb *f* @ 70°F: | 40 min | 122, 118, 116<br>119 avg. |
| Avg Charpy Impact: ft•lb *f* @ 32°F: | 40 min | 104, 110, 105<br>106 avg. |

This product meets the requirements for a 60 Day exposure at 80°F, 80% humidity.

This certification expires in October, 2017.

**The undersigned certifies that the product supplied will meet the requirements of the applicable AWS Specification when tested in accordance with that specification, and that no significant change has been made in the formulations and manufacturing procedures described in the qualification approval.**

**Signed by:** _____

**Ben A. Pletcher, Technical Director**