



## 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: **3816H409A9206**  
 Test No: 15089-11, 15089-12

This is to certify that **Select 727** electrode, classification **E71T-1C, -9C** 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 **1/16"** 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: 212  
 Arc Voltage: 25  
 Current Polarity: DCEP  
 Electrical Extension (in): 3/4  
 Shielding Gas: 100CO2  
 No. of Passes/Layers: 7/4  
 Preheat Temp (°F): 250 min.  
 Interpass Temp (°F): 450 min.  
 Heat Input Avg (kJ/in): 81  
 Travel Speed (ipm): 3.9

**LOW HEAT INPUT:**

Amperage: 191  
 Arc Voltage: 25  
 Current Polarity: DCEP  
 Electrical Extension (in): 3/4  
 Shielding Gas: 100CO2  
 No. of Passes/Layers: 15/8  
 Preheat Temp (°F): 120 max.  
 Interpass Temp (°F): 250 max.  
 Heat Input Avg (kJ/in): 31  
 Travel Speed (ipm): 9.3

**TEST RESULTS:**

**HIGH HEAT INPUT:**

Tensile Strength (psi):	70,000 min	72,700
Yield Strength (psi):	58,000 min	60,200
Elongation (%):	22 min	34
Avg Charpy Impact:	40 min	195, 187, 183
ft•lb f @ 70°F:		188 avg.
Avg Charpy Impact:	40 min	140, 140, 133
ft•lb f @ 32°F:		138 avg.

**LOW HEAT INPUT:**

Tensile Strength (psi):	70,000 min	88,700
Yield Strength (psi):	58,000 min	81,800
Elongation (%):	22 min	29
Avg Charpy Impact:	40 min	120, 119, 115
ft•lb f @ 70°F:		118 avg.
Avg Charpy Impact:	40 min	100, 100, 104
ft•lb f @ 32°F:		101 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**