



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: 15089-15, 15089-16

This is to certify that **Select 727** electrode, classification **E71T-1M, -9M** 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 **75%Ar /25%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: 205
 Arc Voltage: 25
 Current Polarity: DCEP
 Electrical Extension (in): 3/4
 Shielding Gas: 75Ar/25CO₂
 No. of Passes/Layers: 7/4
 Preheat Temp (°F): 250 min.
 Interpass Temp (°F): 450 min.
 Heat Input Avg (kJ/in): 78
 Travel Speed (ipm): 4.0

LOW HEAT INPUT:

Amperage: 204
 Arc Voltage: 25.5
 Current Polarity: DCEP
 Electrical Extension (in): 3/4
 Shielding Gas: 75Ar/25CO₂
 No. of Passes/Layers: 15/8
 Preheat Temp (°F): 120 max.
 Interpass Temp (°F): 250 max.
 Heat Input Avg (kJ/in): 33
 Travel Speed (ipm): 9.3

TEST RESULTS:

HIGH HEAT INPUT:

Tensile Strength (psi): 70,000 min
 Yield Strength (psi): 58,000 min
 Elongation (%): 22 min
 Avg Charpy Impact: 40 min
 ft•lb f @ 70°F: 124, 125, 122
 124 avg
 Avg Charpy Impact: 40 min
 ft•lb f @ 32°F: 111, 108, 109
 109 avg

LOW HEAT INPUT:

Tensile Strength (psi): 70,000 min
 Yield Strength (psi): 58,000 min
 Elongation (%): 22 min
 Avg Charpy Impact: 40 min
 ft•lb f @ 70°F: 114, 115, 115
 115 avg
 Avg Charpy Impact: 40 min
 ft•lb f @ 32°F: 98, 100, 100
 99 avg

REQUIREMENTS:

RESULTS:


REQUIREMENTS:

RESULTS:

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