

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 730

Test Completion Date: 2/5/2019

Diameter(s): .045

Lot Numbers: (.045) 3668 3669 3670

Specifications: AWS D1.8:2016

Certificate Expiration Date: 2/5/2022

Classification: E71T-1C, E71T-9C

Weld Parameters - High Heat Input

Lot Number:	3668	3669	3670
Electrode Diameter:	.045	.045	.045
Shielding Gas	CO2	CO2	CO2
Amperage:	187.0	179.0	177.0
Arc Voltage:	26.0	26.0	26.0
Current Polarity:	DCEP	DECP	DCEP
CTWD (in):	3/4	3/4	3/4
No. of Passes/Layers:	8/4	8/4	8/4
Interpass Temperature(°F):	450	450	450
Heat Input Avg.(kJ/in.):	71.4	70.3	71.3

Mechanical Properties - High Heat Input

Lot Number:		3668	3669	3670
Shielding Gas		CO2	CO2	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	68000	67000	67000
Elongation (%):	22 min	32	30	31
Charpy V-Notch Impacts:		121, 138, 126	124, 125, 122	140, 137, 132
ft-lb f @ 70°F	40 avg.	128 avg	124 avg	136 avg
Charpy V-Notch Impacts:		110, 115, 108	111, 108, 111	98, 102, 116
ft-lb f @ 32°F	40 avg.	111 avg	110 avg	105 avg

Weld Parameters - Low Heat Input

Lot Number:	3668	3669	3670
Electrode Diameter:	.045	.045	.045
Shielding Gas	CO2	CO2	CO2
Amperage:	178.0	183.0	175.0
Arc Voltage:	26.0	26.0	26.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	3/4	3/4	3/4
No. of Passes/Layers:	17/8	14/7	13/7
Interpass Temperature(°F):	300	250	250
Heat Input Avg.(kJ/in.):	30.1	34.5	33.1


Mechanical Properties - Low Heat Input

Lot Number:		3668	3669	3670
Shielding Gas		CO2	CO2	CO2
Requirements		Results	Results	Results
Test Condition:	As-Welded	As-Welded	As-Welded	As-Welded
PWHT Temperature:	-	-	-	-
Tensile Strength (psi):	70000 min	86000	80000	89000
Yield Strength (psi):	58000 min	80000	69000	81000
Elongation (%):	22 min	28	30	25
Charpy V-Notch Impacts:		132, 131, 132	152, 147, 152	133, 131, 135
ft-lb f @ 70°F	40 avg.	132 avg	150 avg	133 avg
Charpy V-Notch Impacts:		113, 108, 108	98, 125, 98	125, 110, 112
ft-lb f @ 32°F	40 avg.	110 avg	107 avg	116 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