

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 730C

Test Completion Date: 1/31/2019

Diameter(s): .045

Lot Numbers: (.045) 3665 3666 3667

Specifications: AWS D1.8:2016

Certificate Expiration Date: 1/31/2022

Classification: E71T-1C, E71T-9C

Weld Parameters - High Heat Input

Lot Number:	3665	3666	3667
Electrode Diameter:	.045	.045	.045
Shielding Gas	CO2	CO2	CO2
Amperage:	184.0	188.0	188.0
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:	7/3	8/4	8/4
Interpass Temperature(°F):	450	450	450
Heat Input Avg.(kJ/in.):	71.6	70.2	72.2

Mechanical Properties - High Heat Input

Lot Number:		3665	3666	3667
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	79000	83000	78000
Yield Strength (psi):	58000 min	66000	69000	65000
Elongation (%):	22 min	29	27	30
Charpy V-Notch Impacts:		122, 123, 117	113, 125, 124	138, 124, 142
ft-lb f @ 70°F	40 avg.	121 avg	121 avg	135 avg
Charpy V-Notch Impacts:		61, 68, 91	85, 84, 85	95, 88, 99
ft-lb f @ 32°F	40 avg.	73 avg	85 avg	94 avg

Weld Parameters - Low Heat Input

Lot Number:	3665	3666	3667
Electrode Diameter:	.045	.045	.045
Shielding Gas	CO2	CO2	CO2
Amperage:	185.0	169.0	163.0
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:	17/7	14/7	16/8
Interpass Temperature(°F):	250	250	250
Heat Input Avg.(kJ/in.):	30.6	33.6	30.6


Mechanical Properties - Low Heat Input

Lot Number:		3665	3666	3667
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	84000	81000	82000
Yield Strength (psi):	58000 min	75000	71000	72000
Elongation (%):	22 min	28	28	28
Charpy V-Notch Impacts:		135, 137, 140	186, 164, 182	141, 173, 165
ft-lb f @ 70°F	40 avg.	137 avg	177 avg	160 avg
Charpy V-Notch Impacts:		117, 122, 119	116, 123, 122	122, 126, 120
ft-lb f @ 32°F	40 avg.	119 avg	120 avg	123 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