



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: **0650D510A4801, 0630D510A4801, 0652D510A4801**
 Test No: WC247A, WC247B, WC247C, WC247D, WC247E, WC247F

This is to certify that **Select 78** electrode, classification **E71T-8-H8** 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"**, 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: 300
 Arc Voltage: 22.0
 Current Polarity: DCEN
 Electrical Extension (in): 1.0
 Shielding Gas: None
 No. of Passes/Layers: 8/5
 Preheat Temp (°F): 250 min.
 Interpass Temp (°F): 450 min.
 Heat Input Avg (kJ/in): 75
 Travel Speed (ipm): 5.3

LOW HEAT INPUT:

Amperage: 297
 Arc Voltage: 22
 Current Polarity: DCEN
 Electrical Extension (in): 1.0
 Shielding Gas: None
 No. of Passes/Layers: 19/7
 Preheat Temp (°F): RT
 Interpass Temp (°F): 250 max.
 Heat Input Avg (kJ/in): 29
 Travel Speed (ipm): 13.4

TEST RESULTS:

HIGH HEAT INPUT:

Tensile Strength (psi):
 Yield Strength (psi):
 Elongation (%):
 Avg Charpy Impact
 ft•lb f @ 70°F:
 Avg Charpy Impact
 ft•lb f @ 32°F:

LOW HEAT INPUT:

Tensile Strength (psi):
 Yield Strength (psi):
 Elongation (%):
 Avg Charpy Impact
 ft•lb f @ 70°F:
 Avg Charpy Impact
 ft•lb f @ 32°F:

REQUIREMENTS:

70,000 min
 58,000 min
 22 min
 40 min
 40 min

LOT 0650:

78,200
 59,800
 26.6
 88, 90, 90
 89 avg.
 72, 73, 69
 71 avg.

LOT 0630:

77,200
 60,200
 29.5
 75, 72, 75
 74 avg.
 65, 68, 70
 68 avg.


LOT 0652:

77,100
 58,600
 30.6
 74, 73, 75
 74 avg.
 70, 65, 66
 67 avg.

This product meets the requirements for a 7 Day exposure at 80°F, 80% humidity.

This certification expires in May, 2018.

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