



Manufactured In The USA

Diameter: 1/16

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: SelectAlloy 309L

Test Completion Date: 11/30/2017

Diameter(s): .045 - 1/16

Lot Numbers: (1/16) TO-611

Specifications: AWS A5.22:2012

Classification: E309LT0-1, E309LT0-4

Chemical Analysis

Diameter			.045		1/16	
Shielding Gas			75-80% Ar / Bal CO2	CO2	75-80% Ar / Bal CO2	CO2
	Max	Min	Results	Results	Results	Results
C	0.04	-	0.03	0.03	0.04	0.04
Cr	25.00	22.00	23.29	23.34	23.61	23.23
Cu	0.75	-	0.16	0.16	0.16	0.16
Mn	2.50	0.50	1.70	1.60	1.60	1.50
Mo	0.75	-	0.10	0.10	0.10	0.10
Ni	14.00	12.00	13.15	12.90	12.78	12.78
P	0.040	-	0.021	0.019	0.020	0.021
S	0.030	-	0.007	0.006	0.004	0.004
Si	1.00	-	0.93	0.96	0.91	0.83

Radiographic Test: Met Requirement

Bend Test: Met Requirement

Weld Parameters

Electrode Diameter:	1/16	
Shielding Gas	75-80% Ar / Bal CO2	CO2
Amperage:	207.0	226.0
Arc Voltage:	27.5	28.5
Current Polarity:	DCEP	DCEP
Electrical Extension(in):	3/4	3/4
No. of Passes/Layers:	13/6	13/6
Interpass Temperature(°F):	300	300

Mechanical Properties

Electrode Diameter:		1/16	
Shielding Gas		75-80% Ar / Bal CO2	CO2
Requirements		Results	Results
Test Condition:	As-Welded	As-Welded	As-Welded
PWHT Temperature:	-	-	-
Tensile Strength (psi):	80000 min	85000	83000
Yield Strength (psi):	-	63000	62000
Elongation (%):	30 min	35	35

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: _____

Martin L. Caruso, Director of Technology