

Diameter: 1/16

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 70C-6LS

Test Completion Date: 10/17/2019

Diameter(s): 1/16

Lot Numbers: (1/16) 0021 0212 9954

Specifications: AWS D1.8: 2016

Certificate Expiration Date: 10/17/2022

Classification: E70C-6M

Weld Parameters - High Heat Input

Lot Number:	0021	0212	9954
Electrode Diameter:	1/16	1/16	1/16
Shielding Gas	75%Ar / 25%CO2	75%Ar / 25%CO2	75%Ar / 25%CO2
Amperage:	326.0	338.0	316.0
Arc Voltage:	30.0	30.0	30.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	1	1	1
No. of Passes/Layers:	8/5	9/5	8/5
Interpass Temperature(°F):	450	450	450
Heat Input Avg.(kJ/in.):	67	67	67.3

Mechanical Properties - High Heat Input

Lot Number:		0021	0212	9954
Shielding Gas		75%Ar / 25%CO2	75%Ar / 25%CO2	75%Ar / 25%CO2
Requirements		Results	Results	Results
Test Condition:	As-Welded	As-Welded	As-Welded	As-Welded
PWHT Temperature:	-	-	-	-
Tensile Strength (psi):	70000 min	77000	73000	79000
Yield Strength (psi):	58000 min	60000	58000	65000
Elongation (%):	22 min	30	33	29
Charpy V-Notch Impacts:		131, 128, 139	157, 155, 157	140, 141, 146
ft-lb f @ 70°F	40 avg.	133 avg.	156 avg.	142 avg.
Charpy V-Notch Impacts:		115, 119, 115	118, 139, 114	124, 122, 123
ft-lb f @ 32°F	40 avg.	116 avg.	124 avg.	123 avg.

Weld Parameters - Low Heat Input

Lot Number:	0021	0212	9954
Electrode Diameter:	1/16	1/16	1/16
Shielding Gas	75%Ar / 25%CO2	75%Ar / 25%CO2	75%Ar / 25%CO2
Amperage:	287.0	324.0	300.0
Arc Voltage:	27.0	27.0	27.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	1	1	1
No. of Passes/Layers:	16/8	16/6	15/6
Interpass Temperature(°F):	250	250	250
Heat Input Avg.(kJ/in.):	27.7	27.8	28.3


Mechanical Properties - Low Heat Input

Lot Number:		0021	0212	9954
Shielding Gas		75%Ar / 25%CO2	75%Ar / 25%CO2	75%Ar / 25%CO2
Requirements		Results	Results	Results
Test Condition:	As-Welded	As-Welded	As-Welded	As-Welded
PWHT Temperature:	-	-	-	-
Tensile Strength (psi):	70000 min	89000	83000	83000
Yield Strength (psi):	58000 min	75000	71000	70000
Elongation (%):	22 min	27	27	27
Charpy V-Notch Impacts:		104, 99, 110	105, 109, 110	121, 114, 117
ft-lb f @ 70°F	40 avg.	104 avg.	108 avg.	117 avg.
Charpy V-Notch Impacts:		74, 80, 75	93, 85, 71	85, 103, 105
ft-lb f @ 32°F	40 avg.	76 avg.	83 avg.	98 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