

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 70TR

Test Completion Date: 11/25/2019

Diameter(s): 1/16

Lot Numbers: (1/16) 0048 0161 0855

Specifications: AWS D1.8:2016

Certificate Expiration Date: 11/25/2022

Classification: E70T-1M, E70T-9M

Weld Parameters - High Heat Input

Lot Number:	0048	0161	0855
Electrode Diameter:	1/16	1/16	1/16
Shielding Gas	75%Ar / 25%CO2	75%Ar / 25%CO2	75%Ar / 25%CO2
Amperage:	334.0	322.0	328.0
Arc Voltage:	32.0	30.0	30.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	1	1	1
No. of Passes/Layers:	8/6	8/6	7/5
Interpass Temperature(°F):	450	450	450
Heat Input Avg.(kJ/in.):	70.5	68.7	68.4

Mechanical Properties - High Heat Input

Lot Number:		0048	0161	0855
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	82000	82000
Yield Strength (psi):	58000 min	64000	67000	67000
Elongation (%):	22 min	30	28	29
Charpy V-Notch Impacts:		106, 106, 108	96, 91, 91	96, 93, 93
ft-lb f @ 70°F	40 avg.	107 avg	93 avg	94 avg
Charpy V-Notch Impacts:		73, 71, 60	60, 64, 67	60, 73, 65
ft-lb f @ 32°F	40 avg.	68 avg	64 avg	66 avg

Weld Parameters - Low Heat Input

Lot Number:	0048	0161	0855
Electrode Diameter:	1/16	1/16	1/16
Shielding Gas	75%Ar / 25%CO2	75%Ar / 25%CO2	75%Ar / 25%CO2
Amperage:	198.0	183.0	192.0
Arc Voltage:	26.0	26.0	26.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	1	1	1
No. of Passes/Layers:	18/8	16/8	18/8
Interpass Temperature(°F):	250	250	250
Heat Input Avg.(kJ/in.):	30.1	30.4	29

Mechanical Properties - Low Heat Input

Lot Number:		0048	0161	0855
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	81000	86000	84000
Yield Strength (psi):	58000 min	69000	74000	73000
Elongation (%):	22 min	28	28	25
Charpy V-Notch Impacts:		130, 134, 128	112, 120, 119	122, 121, 114
ft-lb f @ 70°F	40 avg.	131 avg	117 avg	119 avg
Charpy V-Notch Impacts:		104, 106, 105	81, 77, 84	94, 87, 105
ft-lb f @ 32°F	40 avg.	105 avg	81 avg	95 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