

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 721

Test Completion Date: 10/24/2017

Diameter(s): .052

Lot Numbers: (.052) 2333 2334 2335

Specifications: AWS D1.8:2016

Certificate Expiration Date: 10/24/2020

Classification: E71T-1M, E71T-9M, E71T-12M

Weld Parameters - High Heat Input

Lot Number:	2333	2334	2335
Electrode Diameter:	.052	.052	.052
Shielding Gas	90/10	90/10	90/10
Amperage:	215.0	215.0	215.0
Arc Voltage:	22.5	22.5	22.5
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	1	1	1
No. of Passes/Layers:	6/4	6/4	6/3
Interpass Temperature(°F):	450	450	450
Heat Input Avg.(kJ/in.):	72.6	74.4	74.4

Mechanical Properties - High Heat Input

Lot Number:		2333	2334	2335
Shielding Gas		90/10	90/10	90/10
Requirements		Results	Results	Results
Test Condition:	As-Welded	As-Welded	As-Welded	As-Welded
PWHT Temperature:	-	-	-	-
Tensile Strength (psi):	70000 min	83000	83000	84000
Yield Strength (psi):	58000 min	69000	69000	69000
Elongation (%):	22 min	30	27	28
Charpy V-Notch Impacts:		130, 134, 132	134, 139, 137	147, 152, 148
ft-lb f @ 70°F	40 avg.	132 avg	137 avg	149 avg
Charpy V-Notch Impacts:		123, 133, 134	143, 134, 135	125, 149, 146
ft-lb f @ 32°F	40 avg.	130 avg	137 avg	140 avg

Weld Parameters - Low Heat Input

Lot Number:	2333	2334	2335
Electrode Diameter:	.052	.052	.052
Shielding Gas	90/10	90/10	90/10
Amperage:	275.0	275.0	275.0
Arc Voltage:	25.5	25.5	25.5
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	1	1	1
No. of Passes/Layers:	12/6	13/7	13/7
Interpass Temperature(°F):	250	250	250
Heat Input Avg.(kJ/in.):	27.9	29	27.8

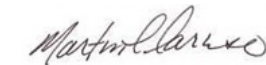
Mechanical Properties - Low Heat Input

Lot Number:		2333	2334	2335
Shielding Gas		90/10	90/10	90/10
Requirements		Results	Results	Results
Test Condition:	As-Welded	As-Welded	As-Welded	As-Welded
PWHT Temperature:	-	-	-	-
Tensile Strength (psi):	70000 min	94000	95000	97000
Yield Strength (psi):	58000 min	86000	88000	89000
Elongation (%):	22 min	23	22	26
Charpy V-Notch Impacts:		111, 104, 103	123, 123, 131	122, 123, 122
ft-lb f @ 70°F	40 avg.	106 avg	126 avg	122 avg
Charpy V-Notch Impacts:		104, 106, 103	120, 120, 123	121, 125, 124
ft-lb f @ 32°F	40 avg.	104 avg	121 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: _____



Martin L. Caruso, Director of Technology