

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: 10/6/2017

Diameter(s): 1/16

Lot Numbers: (1/16) 2336 2337 2338

Specifications: AWS D1.8:2016

Certificate Expiration Date: 10/6/2020

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

Weld Parameters - High Heat Input

Lot Number:	2336	2337	2338
Electrode Diameter:	1/16	1/16	1/16
Shielding Gas	90/10	90/10	90/10
Amperage:	263.7	279.1	274.1
Arc Voltage:	24.3	24.5	24.3
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	3/4	3/4	3/4
No. of Passes/Layers:	8/5	8/5	12/5
Interpass Temperature(°F):	450	450	450
Heat Input Avg.(kJ/in.):	80.7	81.3	79.9

Mechanical Properties - High Heat Input

Lot Number:		2336	2337	2338
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	84000	83000
Yield Strength (psi):	58000 min	71000	72000	74000
Elongation (%):	22 min	28	24	28
Charpy V-Notch Impacts:		118, 118, 119	119, 122, 121	109, 110, 110
ft-lb f @ 70°F	40 avg.	118 avg	121 avg	110 avg
Charpy V-Notch Impacts:		121, 125, 119	125, 125, 121	111, 109, 108
ft-lb f @ 32°F	40 avg.	122 avg	124 avg	109 avg

Weld Parameters - Low Heat Input

Lot Number:	2336	2337	2338
Electrode Diameter:	1/16	1/16	1/16
Shielding Gas	90/10	90/10	90/10
Amperage:	327.8	314.7	324.4
Arc Voltage:	26.3	26.3	26.3
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	3/4	3/4	3/4
No. of Passes/Layers:	16/6	16/6	17/6
Interpass Temperature(°F):	250	250	250
Heat Input Avg.(kJ/in.):	31.3	30.1	31.0

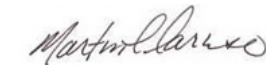
Mechanical Properties - Low Heat Input

Lot Number:		2336	2337	2338
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	88000	90000	85000
Yield Strength (psi):	58000 min	81000	85000	71000
Elongation (%):	22 min	27	25	26
Charpy V-Notch Impacts:		113, 115, 116	125, 124, 122	95, 90, 90
ft-lb f @ 70°F	40 avg.	115 avg	124 avg	92 avg
Charpy V-Notch Impacts:		114, 111, 116	120, 121, 121	90, 90, 90
ft-lb f @ 32°F	40 avg.	114 avg	121 avg	90 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