

Diameter: .045

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 727

Test Completion Date: 6/9/2020

Diameter(s): .045

Lot Numbers: (.045) 5733

Lot Class: 'T4' per AWS A5.01

Certificate Expiration Date: 6/9/2023

Specifications: AWS D1.8:2016

Classification: E71T-1M, E71T-9M

Weld Parameters - High Heat Input

Lot Number:	5733
Electrode Diameter:	.045
Shielding Gas	75%Ar / 25%CO2
Amperage:	203.0
Arc Voltage:	25.0
Current Polarity:	DCEP
CTWD (in):	3/4
No. of Passes/Layers:	8/5
Interpass Temperature(°F):	450
Heat Input Avg.(kJ/in.):	66.1

Mechanical Properties - High Heat Input

Lot Number:		5733
Shielding Gas		75%Ar / 25%CO2
Requirements		Results
Test Condition:	As-Welded	As-Welded
PWHT Temperature:	-	-
Tensile Strength (psi):	70000 min	86000
Yield Strength (psi):	58000 min	76000
Elongation (%):	22 min	24
Charpy V-Notch Impacts:		121, 122, 122
ft-lb f @ 70°F	40 avg.	122 avg
Charpy V-Notch Impacts:		108, 112, 116
ft-lb f @ 32°F	40 avg.	112 avg

Weld Parameters - Low Heat Input

Lot Number:	5733
Electrode Diameter:	.045
Shielding Gas	75%Ar / 25%CO2
Amperage:	189.0
Arc Voltage:	25.0
Current Polarity:	DCEP
CTWD (in):	3/4
No. of Passes/Layers:	16/8
Interpass Temperature(°F):	250
Heat Input Avg.(kJ/in.):	31.7

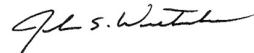
Mechanical Properties - Low Heat Input

Lot Number:		5733
Shielding Gas		75%Ar / 25%CO2
Requirements		Results
Test Condition:	As-Welded	As-Welded
PWHT Temperature:	-	-
Tensile Strength (psi):	70000 min	97000
Yield Strength (psi):	58000 min	90000
Elongation (%):	22 min	26
Charpy V-Notch Impacts:		112, 115, 107
ft-lb f @ 70°F	40 avg.	111 avg
Charpy V-Notch Impacts:		83, 95, 88
ft-lb f @ 32°F	40 avg.	88 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