

Diameter: .052

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: 6/5/2020

Diameter(s): .052

Lot Numbers: (.052) 4054

Lot Class: 'T4' per AWS A5.01

Certificate Expiration Date: 6/5/2023

Specifications: AWS D1.8:2016

Classification: E71T-1M, E71T-9M

Weld Parameters - High Heat Input

Lot Number:	4054
Electrode Diameter:	.052
Shielding Gas	75%Ar / 25%CO2
Amperage:	220.0
Arc Voltage:	24.0
Current Polarity:	DCEP
CTWD (in):	3/4
No. of Passes/Layers:	8/4
Interpass Temperature(°F):	450
Heat Input Avg.(kJ/in.):	71.1

Mechanical Properties - High Heat Input

Lot Number:		4054
Shielding Gas		75%Ar / 25%CO2
Requirements		Results
Test Condition:	As-Welded	As-Welded
PWHT Temperature:	-	-
Tensile Strength (psi):	70000 min	87000
Yield Strength (psi):	58000 min	75000
Elongation (%):	22 min	26
Charpy V-Notch Impacts:		116, 105, 101
ft-lb f @ 70°F	40 avg.	107 avg
Charpy V-Notch Impacts:		95, 88, 90
ft-lb f @ 32°F	40 avg.	91 avg

Weld Parameters - Low Heat Input

Lot Number:	4054
Electrode Diameter:	.052
Shielding Gas	75%Ar / 25%CO2
Amperage:	213.0
Arc Voltage:	24.0
Current Polarity:	DCEP
CTWD (in):	3/4
No. of Passes/Layers:	16/8
Interpass Temperature(°F):	250
Heat Input Avg.(kJ/in.):	28.8

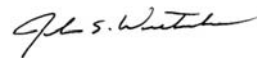
Mechanical Properties - Low Heat Input

Lot Number:		4054
Shielding Gas		75%Ar / 25%CO2
Requirements		Results
Test Condition:	As-Welded	As-Welded
PWHT Temperature:	-	-
Tensile Strength (psi):	70000 min	91000
Yield Strength (psi):	58000 min	83000
Elongation (%):	22 min	28
Charpy V-Notch Impacts:		106, 105, 108
ft-lb f @ 70°F	40 avg.	106 avg
Charpy V-Notch Impacts:		93, 84, 92
ft-lb f @ 32°F	40 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: _____



Joshua S Westerheide, Quality Manager