

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 730

Test Completion Date: 1/28/2019

Diameter(s): .045

Lot Numbers: (.045) 3668 3669 3670

Specifications: AWS D1.8:2016

Certificate Expiration Date: 1/28/2022

Classification: E71T-1M, E71T-9M

Weld Parameters - High Heat Input

Lot Number:	3668	3669	3670
Electrode Diameter:	.045	.045	.045
Shielding Gas	75%Ar / 25%CO2	75%Ar / 25%CO2	75%Ar / 25%CO2
Amperage:	208.0	185.0	189.0
Arc Voltage:	25.0	25.0	25.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	3/4	3/4	3/4
No. of Passes/Layers:	8/4	8/4	8/4
Interpass Temperature(°F):	450	450	450
Heat Input Avg.(kJ/in.):	68.7	71.6	71.1

Mechanical Properties - High Heat Input

Lot Number:		3668	3669	3670
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	92000	87000	88000
Yield Strength (psi):	58000 min	79000	72000	75000
Elongation (%):	22 min	28	26	27
Charpy V-Notch Impacts:		122, 119, 119	119, 113, 118	130, 128, 130
ft-lb f @ 70°F	40 avg.	120 avg	117 avg	129 avg
Charpy V-Notch Impacts:		98, 107, 107	100, 103, 108	109, 106, 108
ft-lb f @ 32°F	40 avg.	104 avg	104 avg	108 avg

Weld Parameters - Low Heat Input

Lot Number:	3668	3669	3670
Electrode Diameter:	.045	.045	.045
Shielding Gas	75%Ar / 25%CO2	75%Ar / 25%CO2	75%Ar / 25%CO2
Amperage:	174.0	189.0	169.0
Arc Voltage:	25.0	25.0	25.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	3/4	3/4	3/4
No. of Passes/Layers:	14/7	16/8	15/7
Interpass Temperature(°F):	250	250	250
Heat Input Avg.(kJ/in.):	31.4	29.3	30.4

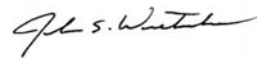
Mechanical Properties - Low Heat Input

Lot Number:		3668	3669	3670
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	94000	91000	99000
Yield Strength (psi):	58000 min	84000	82000	89000
Elongation (%):	22 min	27	27	24
Charpy V-Notch Impacts:		139, 146, 143	133, 137, 140	85, 88, 80
ft-lb f @ 70°F	40 avg.	143 avg	137 avg	84 avg
Charpy V-Notch Impacts:		135, 135, 126	115, 111, 121	79, 83, 75
ft-lb f @ 32°F	40 avg.	132 avg	116 avg	79 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