

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 730

Test Completion Date: 12/14/2018

Diameter(s): .052

Lot Numbers: (.052) 1899 1900 1901

Specifications: AWS D1.8:2016

Certificate Expiration Date: 12/14/2021

Classification: E71T-1M, E71T-9M

Weld Parameters - High Heat Input

Lot Number:	1899	1900	1901
Electrode Diameter:	.052	.052	.052
Shielding Gas	75%Ar / 25%CO2	75%Ar / 25%CO2	75%Ar / 25%CO2
Amperage:	188.0	202.0	193.0
Arc Voltage:	24.0	24.0	24.0
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.):	71.2	73.1	71.3

Mechanical Properties - High Heat Input

Lot Number:		1899	1900	1901
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	86000	88000	89000
Yield Strength (psi):	58000 min	73000	76000	73000
Elongation (%):	22 min	27	28	29
Charpy V-Notch Impacts:		114, 113, 114	108, 103, 98	111, 114, 107
ft-lb f @ 70°F	40 avg.	114 avg	103 avg	111 avg
Charpy V-Notch Impacts:		102, 101, 101	98, 93, 94	92, 92, 89
ft-lb f @ 32°F	40 avg.	101 avg	95 avg	91 avg

Weld Parameters - Low Heat Input

Lot Number:	1899	1900	1901
Electrode Diameter:	.052	.052	.052
Shielding Gas	75%Ar / 25%CO2	75%Ar / 25%CO2	75%Ar / 25%CO2
Amperage:	202.0	203.0	202.0
Arc Voltage:	24.0	24.0	24.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	3/4	3/4	3/4
No. of Passes/Layers:	16/8	16/8	16/8
Interpass Temperature(°F):	300	300	300
Heat Input Avg.(kJ/in.):	32.5	31.6	31.3

Mechanical Properties - Low Heat Input

Lot Number:		1899	1900	1901
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	95000	90000	95000
Yield Strength (psi):	58000 min	87000	80000	85000
Elongation (%):	22 min	27	26	27
Charpy V-Notch Impacts:		124, 128, 129	126, 133, 129	132, 126, 130
ft-lb f @ 70°F	40 avg.	127 avg	129 avg	129 avg
Charpy V-Notch Impacts:		123, 116, 117	118, 116, 111	115, 116, 107
ft-lb f @ 32°F	40 avg.	119 avg	115 avg	113 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