

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
Diameter(s): 1/16
Specifications: AWS D1.8:2016
Classification: E71T-1C, E71T-9C

Test Completion Date: 10/19/2018
Lot Numbers: (1/16) 0174 0175 0176
Certificate Expiration Date: 10/19/2021

Weld Parameters - High Heat Input

Lot Number:	0174	0175	0176
Electrode Diameter:	1/16	1/16	1/16
Shielding Gas	CO2	CO2	CO2
Amperage:	229.0	224.0	222.5
Arc Voltage:	26.0	26.0	26.0
Current Polarity:	DCEP	DCEP	DCEP
CTWD (in):	3/4	3/4	3/4
No. of Passes/Layers:	9/4	8/4	8/4
Interpass Temperature(°F):	450	450	450
Heat Input Avg.(kJ/in.):	72.4	70.1	72.4

Mechanical Properties - High Heat Input

Lot Number:		0174	0175	0176
Shielding Gas		CO2	CO2	CO2
Requirements		Results	Results	Results
Test Condition:	As-Welded	As-Welded	As-Welded	As-Welded
PWHT Temperature:	-	-	-	-
Tensile Strength (psi):	70000 min	80000	82000	82000
Yield Strength (psi):	58000 min	70000	72000	71000
Elongation (%):	22 min	29	29	32
Charpy V-Notch Impacts:		118, 126, 125	113, 115, 112	130, 131, 121
ft-lb f @ 72°F	40 avg.	123 avg	113 avg	127 avg
Charpy V-Notch Impacts:		57, 82, 73	87, 84, 85	97, 92, 93
ft-lb f @ 32°F	40 avg.	71 avg	85 avg	94 avg

Weld Parameters - Low Heat Input

Lot Number:	0174	0175	0176
Electrode Diameter:	1/16	1/16	1/16
Shielding Gas	CO2	CO2	CO2
Amperage:	200.0	202.0	200.0
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:	17/9	17/9	17/9
Interpass Temperature(°F):	250	250	250
Heat Input Avg.(kJ/in.):	29.2	29.8	31.9

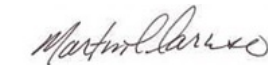
Mechanical Properties - Low Heat Input

Lot Number:		0174	0175	0176
Shielding Gas		CO2	CO2	CO2
Requirements		Results	Results	Results
Test Condition:	As-Welded	As-Welded	As-Welded	As-Welded
PWHT Temperature:	-	-	-	-
Tensile Strength (psi):	70000 min	96000	86000	83000
Yield Strength (psi):	58000 min	86000	80000	77000
Elongation (%):	22 min	23	27	28
Charpy V-Notch Impacts:		136, 124, 131	128, 121, 122	133, 142, 140
ft-lb f @ 72°F	40 avg.	130 avg	124 avg	138 avg
Charpy V-Notch Impacts:		94, 95, 68	97, 84, 97	121, 112, 114
ft-lb f @ 32°F	40 avg.	86 avg	93 avg	116 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