

Diameter: 1/16

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 730C

Test Completion Date: 10/25/2018

Diameter(s): 1/16

Lot Numbers: (1/16) 0177 0178 0179

Specifications: AWS D1.8:2016

Certificate Expiration Date: 10/25/2021

Classification: E71T-1C, E71T-9C

Weld Parameters - High Heat Input

Lot Number:	0177	0178	0179
Electrode Diameter:	1/16	1/16	1/16
Shielding Gas	CO2	CO2	CO2
Amperage:	218.0	224.0	230.0
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:	8/4	9/4	8/4
Interpass Temperature(°F):	450	450	450
Heat Input Avg.(kJ/in.):	71	72.5	71.8

Mechanical Properties - High Heat Input

Lot Number:		0177	0178	0179
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	84000	83000	82000
Yield Strength (psi):	58000 min	74000	72000	73000
Elongation (%):	22 min	29	29	28
Charpy V-Notch Impacts:		82, 48, 57	99, 78, 90	118, 118, 127
ft-lb f @ 72°F	40 avg.	62 avg	89 avg	121 avg
Charpy V-Notch Impacts:		93, 92, 89	56, 53, 48	98, 87, 77
ft-lb f @ 32°F	40 avg.	91 avg	52 avg	87 avg

Weld Parameters - Low Heat Input

Lot Number:	0177	0178	0179
Electrode Diameter:	1/16	1/16	1/16
Shielding Gas	CO2	CO2	CO2
Amperage:	200.0	200.0	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	16/8
Interpass Temperature(°F):	250	250	250
Heat Input Avg.(kJ/in.):	29.9	30	28.2


Mechanical Properties - Low Heat Input

Lot Number:		0177	0178	0179
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	83000	83000	82000
Yield Strength (psi):	58000 min	77000	76000	76000
Elongation (%):	22 min	30	29	27
Charpy V-Notch Impacts:		139, 134, 139	127, 126, 136	153, 179, 147
ft-lb f @ 72°F	40 avg.	137 avg	130 avg	160 avg
Charpy V-Notch Impacts:		113, 115, 116	114, 114, 103	103, 118, 115
ft-lb f @ 32°F	40 avg.	115 avg	110 avg	112 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