



INSPECTION CERTIFICATION

According to EN 10204 3.1

Client	SWP	Heat No.	8396	Date of Delivery	Dec., 26, 2022
Products	Super 6 SG2	Test No.	838396	Date of Production	Dec., 2022
Order no.	41893	Size	0.8mm(1512FLX)	Date of Test	Dec., 22, 2022

All-weld-metal/Chemical analysis(%)-CO2/MIXED GAS

C	Si	Mn	P	S	Cr	Ni	Mo	V	Al	Ti+Zr	Cu
0.09	0.88	1.57	0.012	0.013	0.006	0.006	0.004	0.003	0.002	0.03	0.22

Welding conditions

Current type	DC+	Arc voltage(V)	22-26	Interpass temp.	150
Current(A)	220-260	Shielding Gas	EN ISO 14175-C1,M20,M21		

All-weld-metal mechanical properties

Tensile test

Test no.	Heat treatment	Tensile strength(MPa)	Yield Strength(MPa)	Elongation(%)
838396	-	546	454	28

Impact test

Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
838396	V	-40	M21	92	87	88	88	86	88.20
838396	V	-40	C1	85	84	83	85	83	84.00

Radiography	Bending test(Butt Weld)	Hydrogen Test
II	OK	2.78



Standard no.: AWS A5.18 ER70S-6

EN ISO 14341-A-G 42 4C1/M21 3Si1

DIN 8559 SG2

0036

14

DOP Ref.: Super 6 SG2 2014-001

EN13479:2017

Approvals: TÜV SÜD

CPR Certificate no.:0036-CPR-S 103.2017.001

We hereby certify that the product described above "complies with the term of the order" and conforms with the related international standards"

Inspecting Department : QC Department

Inspector : **Jeremy Packer**

Specialised welding Products Ltd

Unit 1 , Withins Road, Haydock Industrial Estate, Haydock, WA11 9UD

www.specialisedwelding.co.uk



INSPECTION CERTIFICATION

According to EN 10204 3.1

Client	SWP	Heat No.	6149	Date of Delivery	Dec., 26, 2022
Products	Super 6 SG2	Test No.	836149	Date of Production	Dec., 2022
Order no.	41893	Size	1.0mm(1513FLX)	Date of Test	Dec., 22, 2022

All-weld-metal/Chemical analysis(%)-CO2/MIXED GAS

C	Si	Mn	P	S	Cr	Ni	Mo	V	Al	Ti+Zr	Cu
0.08	0.89	1.58	0.013	0.012	0.007	0.005	0.004	0.003	0.002	0.03	0.22

Welding conditions

Current type	DC+	Arc voltage(V)	22-26	Interpass temp.	150
Current(A)	220-260	Shielding Gas	EN ISO 14175-C1,M20,M21		

All-weld-metal mechanical properties

Tensile test

Test no.	Heat treatment	Tensile strength(MPa)	Yield Strength(MPa)	Elongation(%)
836149	-	547	456	28

Impact test

Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
836149	V	-40	M21	92	87	88	92	86	89.00
836149	V	-40	C1	86	84	83	86	83	84.40

Radiography	Bending test(Butt Weld)	Hydrogen Test
II	OK	2.78



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INSPECTION CERTIFICATION

According to EN 10204 3.1

Client	SWP	Heat No.	4473	Date of Delivery	Dec., 26, 2022
Products	Super 6 SG2	Test No.	534473	Date of Production	Dec., 2022
Order no.	41893	Size	1.2mm(1513FLX)	Date of Test	Dec., 22, 2022

All-weld-metal/Chemical analysis(%)-CO2/MIXED GAS

C	Si	Mn	P	S	Cr	Ni	Mo	V	Al	Ti+Zr	Cu
0.09	0.88	1.57	0.012	0.012	0.006	0.005	0.004	0.003	0.002	0.03	0.22

Welding conditions

Current type	DC+	Arc voltage(V)	22-26	Interpass temp.	150
Current(A)	220-260	Shielding Gas	EN ISO 14175-C1,M20,M21		

All-weld-metal mechanical properties

Tensile test

Test no.	Heat treatment	Tensile strength(MPa)	Yield Strength(MPa)	Elongation(%)
534473	-	546	458	28

Impact test

Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
534473	V	-40	M21	91	88	89	90	87	89.00
534473	V	-40	C1	86	85	83	86	84	84.80

Radiography	Bending test(Butt Weld)	Hydrogen Test
II	OK	2.78



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EN ISO 14341-A-G 42 4C1/M21 3Si1

DIN 8559 SG2

0036

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DOP Ref.: Super 6 SG2 2014-001

EN13479:2017

Approvals: TÜV SÜD

CPR Certificate no.: 0036-CPR-S 103.2017.001

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Inspecting Department : QC Department

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