



INSPECTION CERTIFICATION

According to EN 10204 3.1

Client	SWP	Heat No.	5849	Date of Delivery	Dec., 19, 2022
Products	Super 6 SG2	Test No.	835849	Date of Production	Dec., 2022
Order no.	41611	Size	0.8mm(7304)	Date of Test	Dec., 16, 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	1.56	0.012	0.012	0.0045	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(%)
835849	-	547	458	27

Impact test

Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
835849	V	-40	M21	89	91	92	88	87	89.40
835849	V	-40	C1	83	85	84	85	84	84.20

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

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