



# INSPECTION CERTIFICATION

According to EN 10204 3.1

Client	SWP	Heat No.	4864	Date of Delivery	Dec., 19, 2022
Products	<b>Super 6 SG2</b>	Test No.	834864	Date of Production	Dec., 2022
Order no.	41600	Size	0.8mm(7307)	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
0.08	0.87	1.58	0.013	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(%)	
834864	-	547			457			28	
Impact test									
Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
834864	V	-40	M21	91	90	93	89	88	90.20
834864	V	-40	C1	86	85	84	85	84	84.80
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

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# INSPECTION CERTIFICATION

According to EN 10204 3.1

Client	SWP	Heat No.	4332	Date of Delivery	Dec., 19, 2022
Products	<b>Super 6 SG2</b>	Test No.	834332	Date of Production	Dec., 2022
Order no.	41600	Size	1.0mm(1513DUB)	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	0.89	1.57	0.013	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(%)	
834332	-	546			458			28	
Impact test									
Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
834332	V	-40	M21	91	92	88	89	89	89.80
834332	V	-40	C1	84	86	84	85	85	84.80
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

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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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Inspector : **Jeremy Packer**

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# INSPECTION CERTIFICATION

According to EN 10204 3.1

Client	SWP	Heat No.	4890	Date of Delivery	Dec., 19, 2022
Products	<b>Super 6 SG2</b>	Test No.	534890	Date of Production	Dec., 2022
Order no.	41600	Size	1.2mm(1514DUB)	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	0.86	1.57	0.012	0.012	0.005	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(%)	
534890	-	546			454			28	
Impact test									
Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
534890	V	-40	M21	91	90	92	88	88	89.80
534890	V	-40	C1	87	86	85	85	84	85.40
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  
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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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