



INSPECTION CERTIFICATION

According to EN 10204 3.1

Client	SWP	Heat No.	6871	Date of Delivery	Dec., 26, 2022
Products	Super 6 SG2	Test No.	836871	Date of Production	Dec., 2022
Order no.	41822	Size	0.8mm(7307)	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	1.59	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(%)	
836871	-	548			456			28	
Impact test									
Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
836871	V	-40	M21	89	90	91	89	88	89.40
836871	V	-40	C1	86	85	86	85	84	85.20
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**

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.	8404	Date of Delivery	Dec., 26, 2022
Products	Super 6 SG2	Test No.	838404	Date of Production	Dec., 2022
Order no.	41822	Size	1.0mm(7308)	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	0.006	0.004	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(%)	
838404	-	547			458			28	
Impact test									
Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
838404	V	-40	M21	88	92	89	87	89	89.00
838404	V	-40	C1	84	85	86	85	86	85.20
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.	4472	Date of Delivery	Dec., 26, 2022
Products	Super 6 SG2	Test No.	534472	Date of Production	Dec., 2022
Order no.	41822	Size	1.2mm(7309)	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	0.013	0.012	0.006	0.004	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(%)	
534472	-	547			458			28	
Impact test									
Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
534472	V	-40	M21	89	91	88	89	88	89.00
534472	V	-40	C1	84	85	84	85	87	85.00
Radiography			Bending test(Butt Weld)				Hydrogen Test		
II			OK				2.78		



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DOP Ref.: Super 6 SG2 2014-001
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Approvals: TÜV SÜD
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Inspecting Department : QC Department
 Inspector : **Jeremy Packer**