



INSPECTION CERTIFICATION

According to EN 10204 3.1

Client	SWP	Heat No.	1141	Date of Delivery	April 20, 2023
Products	Super 6 SG2	Test No.	831141	Date of Production	April, 2023
Order no.	42227	Size	1.0mm(7308)	Date of Test	April 10, 2023

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	1.56	0.012	0.013	0.005	0.004	0.004	0.003	0.002	0.03	0.22

Welding conditions

Current type	DC+	Arc voltage(V)	22-26	Inter pass 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(%)	
831141	-	546			457			28	
Impact test									
Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
831141	V	-40	M21	92	89	87	92	88	89.60
831141	V	-40	C1	84	82	84	82	83	83.00
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

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DOP Ref.: Super 6 SG2 2017-001

EN13479:2017

Approvals: TÜV SÜD

CPR Certificate no.: 0036-CPR-S 128.2020.001

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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