



INSPECTION CERTIFICATION

According to EN 10204 3.1

Client	SWP	Heat No.	0090	Date of Delivery	Sep.26,2023
Products	Super 6 SG2	Test No.	530090	Date of Production	Sep.,2023
Order no.	43162	Size	1.2mm(7309)	Date of Test	Sep.,22,2023

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	0.006	0.005	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(%)	
530090	-	548			457			27	
Impact test									
Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
530090	V	-40	M21	93	94	93	91	92	92.60
530090	V	-40	C1	84	85	84	86	84	84.60
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

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"



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14

DOP Ref.:Super 6 SG2 2017-001
 EN13479:2017

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