



# INSPECTION CERTIFICATION

According to EN 10204 3.1

|           |                    |          |             |                    |                |
|-----------|--------------------|----------|-------------|--------------------|----------------|
| Client    | SWP                | Heat No. | 4474        | Date of Delivery   | Jan., 10, 2023 |
| Products  | <b>Super 6 SG2</b> | Test No. | 534474      | Date of Production | Jan., 2023     |
| Order no. | 41875              | Size     | 1.2mm(7309) | Date of Test       | Jan., 6, 2023  |

### 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 | 0.012 | 0.013 | 0.006 | 0.007 | 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(%) |         |
| 534474       | -              | 547                   |                         |                 | 458                 |               |    | 28            |         |
| Impact test  |                |                       |                         |                 |                     |               |    |               |         |
| Test no.     | Notch type     | Test temperature      | Shielding Gas           | Impact value(J) |                     |               |    |               | Average |
|              |                |                       |                         | 1               | 2                   | 3             | 4  | 5             |         |
| 534474       | V              | -40                   | M21                     | 93              | 89                  | 87            | 88 | 86            | 88.60   |
| 534474       | V              | -40                   | C1                      | 85              | 86                  | 85            | 85 | 84            | 85.00   |
| 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  
 14

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**

Specialised welding Products Ltd

Unit 1 , Withins Road, Haydock Industrial Estate, Haydock, WA11 9UD

[www.specialisedwelding.co.uk](http://www.specialisedwelding.co.uk)