



INSPECTION CERTIFICATION

According to EN 10204 3.1

Client	SWP	Heat No.	3911	Date of Delivery	May 21, 2024
Products	SUPER 6SG2	Test No.	833911	Date of Production	May, 2024
Order no.	44243	Size	1.0mm(7313)	Date of Test	May 15, 2024

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	0.012	0.011	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(%)			
839311	-	547		457		28			
Impact test									
Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
839311	V	-40	M21	98	96	95	97	98	96.80
839311	V	-40	C1	84	85	85	83	84	84.20
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

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DOP Ref.: Super 6 SG2 2020-003

EN13479:2017

Approvals: TÜV SÜD

CPR Certificate no.: 0036-CPR-S 128.2020.003

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 : **Gary Waterman**

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