



INSPECTION CERTIFICATION

According to EN 10204 3.1

| | | | | | |
|-----------|-------------------|----------|-------------|--------------------|--------------|
| Client | SWP | Heat No. | 9333 | Date of Delivery | May 21, 2024 |
| Products | SUPER 6SG2 | Test No. | 539333 | Date of Production | May, 2024 |
| Order no. | 44243 | Size | 1.2mm(7314) | 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 | 0.87 | 1.58 | 0.012 | 0.013 | 0.005 | 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(%) | | | |
| 539333 | - | 546 | | 458 | | 28 | | | |
| Impact test | | | | | | | | | |
| Test no. | Notch type | Test temperature | Shielding Gas | Impact value(J) | | | | | Average |
| | | | | 1 | 2 | 3 | 4 | 5 | |
| 539333 | V | -40 | M21 | 97 | 94 | 95 | 96 | 98 | 96.00 |
| 539333 | V | -40 | C1 | 84 | 85 | 85 | 87 | 85 | 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 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**

Specialised welding Products Ltd

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

www.specialisedwelding.co.uk