



TEST CERTIFICATE REPORT

Special wire products

Email : sales@specialwire.in
Web site : www.specialwire.in

Product : STAR
Classification : ER70S-6
Specification : AWS A5.18-2017;ASME SFA A5.18
Batch no : 10F841218RJ01
Size : 1.20MM
MFD : 17.02.2021

Test certificate no : 2849

This is to certify that all tests required by the specifications shown for classification were performed, and the material tested met all requirements. It is manufactured and supplied as per the Quality system program of SPL, which meets the requirements of ISO 9001, ANSI/AWS A5.01 and other specification, as applicable

| OPERATING PARAMETERS | SIZE OF WIRE(MM) | POLARITY CURRENT TYPE | SHIELDING GAS | NOMINAL VOLTAGE,V | NOMINAL CURRENT, A | STICK OUT DISTANCE, MM | GAS FLOW L/M |
|----------------------|------------------|-----------------------|----------------|-------------------|--------------------|------------------------|--------------|
| REQUIREMENTS | 1.20MM | DC+ | 80%Ar +20%CO2 | 20-26 | 120-300 | 15-25 | 15-20 |
| RESULT | 1.16 | DC+ | 80%Ar + 20%CO2 | 22 | 232 | 18 | 19 |

CHEMICAL COMPOSITIONS OF WIRES

| CHEMICAL COMPOSITIONS | C | MN | SI | P | S | CR | V | NI | MO | CU | TI | ZR |
|-----------------------|-----------|-----------|-----------|-----------|----------|----|---|----|----|---------|----|----|
| REQUIREMENTS | 0.06-0.15 | 1.40-1.85 | 0.80-1.15 | 0.025 MAX | 0.035MAX | - | - | - | - | 0.50MAX | - | - |
| RESULT | 0.075 | 1.46 | 0.858 | 0.014 | 0.007 | - | - | - | - | 0.31 | - | - |

MECHANICAL PROPERTIES OF WIRE

| MECHANICAL PROPERTIES | Tensile strength [Mpa] | Yield Strength [Mpa] | Elongation % | Average impact energy J@-30°C |
|-----------------------|------------------------|----------------------|--------------|-------------------------------|
| SPECIFICATION | 480 MIN | 400 MIN | 22 MIN | 27 |
| ACTUAL | 569 | 478 | 23 | 42 |

Note :

This documents meets the requirements of EN10204:3.1

Radiographic inspection : Met requirements

Ref No:128/0007

Quality Assurance