



Test certificate

Special wire products (p) Ltd.,
235, Sidco Industrial Estate,
Ambattur, Chennai-600098

Product : STAR - Ø1.20mm FLUX CORED WIRE
Grade : E71T - 1C , E71T1 - C1A0 - CS1
Character : SFA 5.20 , SFA5.36
Batch No : F938427
Size : Ø 1.2 mm

Test certificate no : 402
Email : sales@specialwires.in
Web site : www.specialwire.in

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 SWP, which meets the requirements of SFA 5.20 - E71T-1C and other specification, as applicable.

OPERATING PARAMETERS	SIZE OF WIRE(MM)	POLARITY CURRENT TYPE	SHIELDING GAS
SPECIFICATION	Ø 1.2 - 0.05	DC+	80%Ar +20%CO2
ACTUAL	Ø1.19	DC+	80%Ar + 20%CO2
RESULT	OK	OK	OK

CHEMICAL COMPOSITIONS OF WIRES

CHEMICAL COMPOSITIONS	C	Mn	Si	P	S
SPECIFICATIONS	0.10% MAX	1.00-1.60%	0.55% MAX	0.025% MAX	0.025% MAX
VALUES	0.042	1.45	0.47	0.021	0.008

MECHANICAL PROPERTIES OF WIRE

MECHANICAL PROPERTIES	Tensile strength [N/mm2]	Yield Strength [N/mm2]	Elongation %	Average impact energy J@-30°C
SPECIFICATIONS	520 MIN	480 MIN	27 MIN	55 MIN
VALUES	627	522	27.3	55

Note :

Radiographic inspection : Met requirements

Ref No:048/0005

DATE:08.10.19



N.
Quality Assurance