Special Wires

STAR

Test certificate

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

Brand	: STAR		
Product	: MIG WELDING WIRE	Test certificate no	: 1538
Classification	: ER70S-6	MFD	: 24.11.2023
Specification	: AWS A5.18-2017;ASME SFA A5.18	Email	: sales@specialwires.in
Batch No	: F947306	Web site	: www.specialwire.in
Size Ø	: 1.20 mm		

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 ANSI/AWS A5.18-2017 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
SPECFICATION	Ø 1.2 - 0.05	DC+	80%Ar + 20%CO2 (or) 100% Co2	20-32	200-350	10 - 20	15-20
ACTUAL	Ø 1.174	DC+	80%Ar + 20%CO2 (or) 100% Co2	22	227	18	16

RESULT : The Operating Parameters met the requirements of AWS A5.18-2017;ASME SFA A5.18

CHEMICAL COMPOSITIONS OF WIRE

CHEMICAL COMPOSITIONS	C	Mn	SI	P	S	Cr	Ni	CU
SPECFICATION	0.06-0.15	1.40-1.85	0.80-1.15	0.025 MAX	0.035MAX	0.150 Max	0.150 Max	0.50MAX
ACTUAL	0.07	1.48	0.868	0.015	0.005	0.025	0.007	0.006

RESULT : The Chemical Composition of the wires met the requirements of AWS A5.18-2017;ASME SFA A5.18

MECHANICAL PROPERTIES OF WELDED

MECHANICAL PROPERTIES	Tensile strength [N/mm2]	Yield Strength [N/mm2]	Elongation %	Average impact energy J@-30°C					
SPECFICATION	480 min	400 min	22 min	27					
				1	2	3	4	5	AVG
ACTUAL	585	517	26	120	128	130	140	122	126

RESULT : The Mechanical Properties of the welded met the requirements of AWS A5.18-2017;ASME SFA A5.18

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Quality Assurance