



**ESAB Welding &  
Cutting Products**

**CERTIFICATE OF CONFORMANCE  
TO SPECIFICATION REQUIREMENTS  
FOR WELDING ELECTRODES**

SECTION NO: 28

SUPPLIED TO:

YOUR ORDER NO.:  
QUANTITY:  
DIAMETER:  
HEAT:

This is to certify that Spoolarc 95 electrode, AWS/ASME Classification ER100S-1-H8, as supplied on the above order, are of the same classification, manufacturing process and material requirements as the electrode combination tested on April 13, 2010 using 98/2 Argon/O<sub>2</sub> shielding gas.

All tests required by Specification AWS /ASME SFA5.28 (F-No. 6) and ANSI/AWS A5.01 Schedule G were performed. The materials tested met all the requirements for Classification ER100S-1-H8. The chemical composition of the electrode and mechanical properties of the deposited weld metal were as follows:

**CHEMICAL COMPOSITION OF ELECTRODE:**

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	V	Ti	Al	Zr	Total Other Elements
.06	1.58	.37	.005	.006	1.82	.09	.39	.07	<.01	.02	<.01	<.01	<.50

WELD TEST NO. 100413-1AW

AS-WELDED

CHARPY V-NOTCH IMPACT  
Ft-Lbs @ -60°F (Joules @ -51°C)

Tensile Test:

Yield Strength, ksi (MPa)	102.0 (703)	102 (138)
Tensile Strength, ksi (MPa)	115.0 (792)	103 (139)
Elongation, 2-in. %	21.5	94 (127)
		102 (138)
		89 (120)
		99 (134) (avg.3)

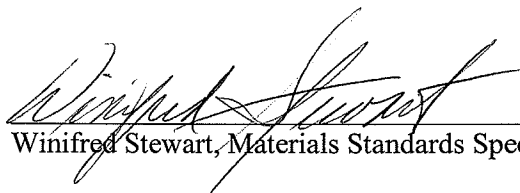
Radiography Test: Met all requirements

Welding Conditions:

Arc Voltage: 25	Base Plate: HY80, 3/4 in. Thick
Amperage: 368 DCEP	Set-up: 45° incl. angle, 1/2 in. Root gap
Travel Speed: 12 ipm	No. of Layers: 3 layers of 2, 1 layer of 3, 1 layers of 4
Diameter: 1/16 in.	Preheat & Interpass: 300 ± 25°F

WELD METAL DIFFUSIBLE HYDROGEN

ml/100g: 2.4, 2.1, 2.7, 2.7 (2.4 avg.)

  
Winifred Stewart, Materials Standards Specialist

COMPANY  
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