

CERTIFICATE OF CONFORMANCE
 TO SPECIFICATION REQUIREMENTS
 FOR WELDING ELECTRODES AND FLUXES

April 27, 2010

SUPPLIED TO: QUANTITY:
 DIAMETER:
 HEAT:
 FLUX LOT:

This is to certify that Spoolarc 70 electrode, Classification EAl, and ESAB OK Flux 350 submerged arc welding flux, AWS/ASME Classification F8TA2-EA1, as supplied on the above order, are of the same classification, manufacturing process and material requirements as the flux-electrode combination tested on March 5, 2010.

All tests required by Specification AWS /ASME SFA5.23 and ANSI/AWS A5.01 Schedule G were performed. The materials tested met all the requirements for Classification F8TA2-EA1. The chemical composition of the electrode and mechanical properties of the deposited weld metal were as follows:


CHEMICAL COMPOSITION OF ELECTRODE							Total
C	Mn	Si	S	P	Mo	Cu	Other Elements
.09	.94	.11	.004	.009	.49	.11	<.50

WELD TEST NO.: R1-4728-10-10247	AS-WELDED	CHARPY V-NOTCH IMPACT	
Radiography Test: Met all requirements		Ft-Lbs @ -20°F (Joules @ -29°C)	
Tensile Test:		25	(34)
Yield Strength, ksi (MPa)	75.3 (519)	25	(34)
Tensile Strength, ksi (MPa)	104.4 (720)	25	(34)
Elongation, 2-in. %	26.0	20	(27)
		<u>21</u>	(28)
		24 (avg.3)	(32) (avg.3)

Welding Conditions:

Arc Voltage: 32 V
 Arc Current: 650 A DCEP
 Travel Speed: 20 ipm
 Wire Diameter: 5/32-in.

Base Plate: A516 Gd. 50, 1/2 in. Thick
 Set-up: Double V, 90° incl. angle, 1/4" root face, no root gap
 No. of Layers: One pass each side
 Preheat/Interpass: RT/211°F max


 Winifred Stewart, Materials Standards Specialist