SWP
Specialised Welding Products Ltd

TÜV NORD ISO 9001

CERTIFICATE

EN 10204

	2.2	3.1
CHEMICAL	X	
MECHANICAL	X	

Number	L - 10840	Date	29.07.2011
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Purchaser	**SPECIALSED WELDING PRODUCTS LTD ENGLAND**
Order Nr	08/SWP/400-2011
Product Group	Covered electrode - stainless, high alloyed
Brand Name	**ELOX R 309 L 17 (SUPER6 E 309L-17)/ 3 KG, PLASTIC BOX**
Standard	AWS A5.4:06 TS 2716 EN 1600:02
Classification	E 309 L - 17 E 23 12 L R 32
Size	**2,50x250 mm**
Quantity	30 Kg
Serial Nr	**2083**
Charge Nr	083

Chemical Composition of Weld Metal (%)

Charge Nr	C	Si	Mn	P	S	Cr	Ni	Mo	Cu	V	Al	Fe	-	-	-	-	-
AWS	*<0,04*	*<1,0*	*0,5-2,5*	*<0,04*	*<0,03*	*22,0-25,0*	*12,0-14,0*	*<0,75*	*<0,75*	-	-	*Rest/Kalan*	-	-	-	-	-
TS/EN/ISO	*<0,04*	*<1,2*	*<2,5*	*<0,03*	*<0,025*	*22,0-25,0*	*11,0-14,0*	-	-	-	-	*Rest/Kalan*	-	-	-	-	-
083	0,026	0,742	0,832	0,020	0,004	22,075	12,265	0,039	0,059	0,032	0,001	Rest(Kalan	-	-	-	-	-

Mechanical Properties

Tensile Test			- EN 10002-1		Impact Test				- EN 10045-1	
Specimen preparation			- EN 876		Specimen preparation				- EN 875 VWT 0/b	
	Test Temperature	R_p Yield Strength	R_m Tensile Strength	A Elong.	Test Temperature	KV Impact Strength	KV Average	Hardness	Radiographic test	Comment
	°C	N / mm²	N / mm²	$\%L_o=5d_o$	°C	J	J	-	-	
AWS	*20*	-	*>520*	*>30*	-	-	-	-	-	
TS/EN/ISO	*20*	*>320*	*>510*	*>25*	-	-	-	-	-	
	20	min. 440	540 - 720	min. 30	20	-	min. 47	-	-	

Quality Department

F186/00

Specialised Welding Products Ltd, Unit 1 Farringdon Industrial Centre, Farringdon, Nr Alton, Hampshire, Gu34 3DD
Telephone: +44 (0) 1420 588180 (Sales) +44 (0) 1420 587308 (Sales Fax) +44 (0) 1420 588923 (Accounts)