

CERTIFICATE



EN 10204

CHEMICAL	<input type="checkbox"/>	<input checked="" type="checkbox"/>
MECHANICAL	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Number	L - 16989	Date:	05.12.2011
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Purchaser	SPECIALISED WELDING PRODUCTS LTD ENGLAND		
Order Nr	12/SWP/649-2011		
Product Group	GMAW/GTAW Wire - Non & Low alloyed		
Brand Name	SG2 (ER 70S6/G3 Si 1-TIG A 18) /5 KG CARTON BOX		
Standard	AWS A5.18:05	TS EN ISO 636-A:09	
Classification	ER 70 S-6	W3Si1	
Size	1,60 mm		
Serial Nr	1164717711		
Charge Nr	177-11		

Chemical Composition of Welding Wire (%)																	
Charge Nr	C	Si	Mn	P	S	Cr	Ni	Mo	Cu*	V	Al	Ti+Zr	-	-	-	-	-
AWS	0,06 - 0,15	0,80 - 1,15	1,40 - 1,85	<0,025	<0,035	<0,15	<0,15	<0,15	<0,50	<0,03	-	-	-	-	-	-	-
TS/EN/ISO	0,06 - 0,14	0,70 - 1,00	1,30 - 1,60	<0,025	<0,025	<0,15	<0,15	<0,15	<0,35	<0,03	<0,02	<0,15	-	-	-	-	-
177-11	0,061	0,817	1,457	0,007	0,009	0,031	0,043	0,014	0,102	0,001	0,002	0,002	-	-	-	-	-

*)Including the copper coating

Mechanical Properties										
Tensile Test					Impact Test					
- EN 10002-1					- EN 10045-1					
Specimen preparation					Specimen preparation					
- EN 876					- 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 / mm ²	N / mm ²	%L ₅₀ =5d ₀	°C	J	J	-	-		
AWS	>400	>480	>22	-30	-	>27	-	-		
TS/EN/ISO	>420	500 - 640	>20	-30	-	>47	-	-		
20	min. 420	500 - 640	min. 22	-30	-	min. 47	-	-		

Comment



Quality Department

F186/00