

Inspection Certificate 46925

Type INETIG S2 Client 301763 SPECIALISED WELDING PRODUCTS L
TIG RODS 14, FARRINGDON INDUSTRIAL CENT
FARRINGDON NR ALTON
GU34 HAMPSHIRE U.K.

INE Order No. 19351 Dated 8/02/2008
Customer Ref. P/O 5015 DT 04.02.08

Norms
AWS A5.18 ER70S-2 EN 1668 W 2 Ti

Reference:

C	Si	Mn	S	P	Cu	Ni	Cr	Mo	Al	V	Ti	Zr
,000	,400	,900	,000	,000	,000	,000	,000	,000	,050	,000	,050	,020
,070	,700	1,400	,035	,025	,500	,150	,150	,150	,150	,030	,150	,120

SECTION 1
CHEMICAL COMPOSITION WIRE:

Heat Number : 12/2182 - 80228
Diam. : mm 2.40

C	Si	Mn	S	P	Cu	Ni	Cr	Mo	Al	V	Ti	Zr
,050	,540	1,200	,004	,006	,150	,030	,030	,010	,124	,010	,110	,060

SECTION 2
MECHANICAL PROPERTIES WELD METAL

			RESULT
Tensile strenght	Rm	480- 680 N/mm ²	580
Yield strenght	Rs	>= 400 N/mm ²	470
Elongation	A5d	>= 22,0 %	27,0
Charpy V-Notch at 29- C°	Kv	>= 27 Joule	80
Hardness	HRC	>= HRC	

We certify that all materials conform to a/m norms.

Document according to UNI EN 10204/2005 - SECTION 1:par.3.1
SECTION 2:par.2.2

During the manufacturing processes, examinations and tests, the material did not come in direct contact with mercury or any of its compounds, nor with any mercury containing device employing a single boundary of containment.