



Certificate of Conformance to Requirements for Welding Electrode

Product Type:	QuantumArc-6
Classification:	ER70S-6
Specifications:	A5.18/SFA 5.18,F-6,,A-1
Diameter Tested:	.045
Date Tested:	5/20/2019
Date Generated:	7/23/2019

This is to certify that the product named above and supplied on the referenced order number is of the same classification, manufacturing process, and material requirements as the material which was used for the test that was concluded on the date shown, the results of which are shown below. All tests required by the specifications shown for classification were performed at that time and the material tested met all requirements. It was manufactured and supplied by the Quality System Program of Hobart Brothers, which meets the requirements of ISO 9001, ANSI/AWS A5.01, and other specification and Military requirements, as applicable. This document supplies actual test results of non-specific inspection in conformance with the requirements of EN 10204, type 2.2 certification.

Test Settings

Shielding Medium	Amps / Polarity	Volts	WFS in/min(m/min)	ESO in(mm)	Preheat F(C)	Interpass F(C)	Travel Speed in/min(cm/min)
C1 (100% CO2)	270 / DCEP	30	445 (11.3)	3/4 (19)	Room Temp	300(149)	10 (25.4)

Mechanical Properties - Tensile

Shielding Medium	Ref. No.	Testing Conditions	Ult. Tensile Strength psi (MPa)	Yield Strength psi (MPa)	Elong.% in 2"
C1 (100% CO2)	PD7915	As Welded	79,000 (543)	63,000 (435)	27

Mechanical Properties - Impact

Shielding Medium	Ref. No.	Testing Conditions	Temp. F (C)	Individuals ft.lb.(J)	Avg. ft.lb.(J)	Type
C1 (100% CO2)	PD7915	As Welded	-20 (-29)	61,62,63 (83,84,85)	62 (84)	Charpy-V-Notch

Ref.No.	Radiographic Inspection		Fillet Weld Test										
Ref.No.			Horizontal :					Overhead :			Vertical :		
PD7915	Conforms												

Chemical Analysis

Shielding Medium / Ref. No	CombC	Mn	P	S	Si	Cu	Cr	V	Ni	Mo	Al	Ti	Nb	Co	B	W	Sn	Fe	Sb	N	Zn	Be	Sb	As
NONE / CD51528	0.08	1.43	0.004	0.012	0.90	0.1	0.06	<.01	0.03	0.01														

A handwritten signature in black ink that reads "Dave A. Thomas".

Dave Thomas, Quality Assurance Rep.

Certification and Limited Warranty - Data for the above supplied product are those obtained when welded and tested in accordance with the above specification. All tests for the above classification were satisfied. Other tests and procedures may produce different results.