

DATE : 10/17/007

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CERTIFICATE OF ANALYSIS

ESAB

CERTIFICATE OF TYPICAL ANALYSIS

ORDER # : 332505
PART NUMBER: 245011655CUSTOMER NAME: PACIFIC INDUSTRIAL SUPPLIES
7 WESTGATE STREET
WACOL QLD 4076
BRISBANE, AUSTRALIACUSTOMERS ORDER NO: 42329
DIAMETER & LENGTH: 5/64
TRADE NAME: DUAL SHIELD
TYPE : II 80-Ni1H4
WEIGHT: 66
LOT NO: 82926
CLASSIFICATION : E 81T1-Ni1MH4
AWS A5.29-98, ASME SFA 5.29CHEMICAL ANALYSIS :

	PROPERTIES	SPEC. REQUIREMENTS
Carbon	0.06	0.12 Max
Manganese	1.26	1.50 Max
Silicon	0.31	0.80 Max
Phosphorus	0.012	0.03 Max
Sulphur	0.008	0.03 Max
Chromium	0.04	0.15 Max
Nickel	0.94	.80 1.10
Molybdenum	0.01	0.35 Max
Vanadium	0.02.01	0.05 Max
Copper	0.04	0.03 Max

RADIOGRAPHY :

XRAY Satisfactory

DIFFUSIBLE HYDROGEN :AVERAGE : .8 (ml/100gr Avg).
GAS USED : 75AR/25CO2TENSILE REQUIREMENTS:

AS WELDED

MIN YIELD(psi) :	68000		
MIN YIELD(Mpa) :	470		
MIN TENSILE(psi) :	80000	MAX TENSILE(psi) :	100000
MIN TENSILE(Mpa) :	550	MAX TENSILE(Mpa) :	690
MIN ELONG :	19.0		

TENSILE RESULTS :

AS WELDED

GAS USED :	75AR/25CO2
CALCULATE YIELD(psi) :	85500
CALCULATE YIELD(Mpa) :	590
CALCULATE TENSILE(psi) :	92200
CALCULATE TENSILE(Mpa) :	636
% ELONGATION :	28.0

The ESAB Group, Inc.

1500 Karen Lane
Hanover, PA 17331
www.esab.com
Fax: 1-800-444-8911
Phone: 1-800-123ESAB

By:

K. Wildasin
K. Wildasin, Supervisor, Q.A. Services

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% REDUCTION OF AREA : 73.6

CHARPY V-NOTCH REQUIREMENTS:AS-WELDED :

CVN TEMPERATURE (F) : -20
CVN TEMPERATURE (C) : -29
CVN AW MIN (FT-LBS) : 20
CVN AW MIN (JOULES) : 27

CHARPY V-NOTCH RESULTS:AS-WELDED :

TEMP (F)	FT-LBS	TEMP (C)	JOULES	GAS
-20	73	-29	99	75AR/25CO2

FILLET : Satisfactory

This material is certified to be free of any mercury.

The undersigned certifies that the product supplied will meet the requirements of the applicable AWS Filler Metal Specification when tested in accordance with that specification, and that no significant change has been made in the elements described in the qualification approval

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