CERTIFICATE OF CONFORMANCE

The Shanghai Lincoln Electric Co., Ltd.
Address: No. 195, Lane 5008, Hu Tai Road, Baoshan, Shanghai, China / 201907
TEL: 8008200269 FAX: 021-56027388

Product: Red Force® 71C
Classification: E71T-1C H8, T 42 2 P C1
Specification: AWS A5.20, ISO 17632-A
Issue Date: 2022/9/19
Customer:

Size: 1.2mm
Quantity:
Lot No.: E229057600
Cert. No.: S22091901

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 test that was concluded on the date shown, the results of which are shown below. All tests required by the specification shown for classification were performed at that time and the material tested met all requirements. It was manufactured and supplied according to the Quality System Program of the Shanghai Lincoln Electric Co., Ltd., which meets the requirements of ISO9001:2015, AWS A5.01 5.2 schedule G, JIS Z3313:2009. The Quality System has been approved by ABS.

Operational Settings	1.2 mm
Wire Feed Speed cm/min(inch/min)	1016(400)
Current (Approx. Amps)	250
Voltage (Volts, DC+)	29
Shielding Gas	CO2
CTWD (mm)	20
Passes/Layers	14/7
Preheat Temp. ˚C (16˚C min.)	28
Interpass Temp. ˚C (150˚ C +/-15˚ C)	150
Weld condition	As-welded

Mechanical properties of weld deposits	AWS/ASME Requirement	ISO Requirement	1.2mm
Tensile Strength, (MPa)	490 - 660	500 - 640	580
Yield Strength 0.2% offset, (MPa)	400 min.	420 min.	510
Elongation (%, A4)	22 min.	20 min.	28
Average Impact Energy Joules (J)@-20℃	27 min.		130 105, 135, 150
Radiographic Inspection	II	II	I
Fillet Weld Test	Horizontal Position	Horizontal Position	Meet Requirements

Deposit composition(%)

C (%)	0.12 max.	-	0.05
Mn (%)	1.60 max.	2.00 max.	1.24
Si (%)	0.90 max.	-	0.38
S (%)	0.030 max.	-	0.008
P (%)	0.030 max.	-	0.012
Ni (%)	-	0.50 max.	0.01
Cr (%)	-	0.20 max.	0.01
Mo (%)	-	0.20 max.	0.01
V (%)	-	0.08 max.	0.01
Nb (%)	-	0.05 max.	0.01
Cu (%)	-	0.3? max.	0.02
Diffusible Hydrogen (ml/100g)	H8		5.8

Other test items: a)Diffusible Hydrogen as per AWS A4.3 / ISO 3690.
Certificate:
WE HEREBY CERTIFY THAT THIS REPORT IS CORRECT AND THAT ALL TEST RESULTS ARE IN COMPLIANCE WITH THE SPECIFICATION DESCRIBED HEREIN.AND THE CERTIFICATE COMPLIES TO THE REQUIREMENTS OF EN10204, Type 2.2 ALSO.

Quality Assurance Administrator: Zhen Chang

Quality Assurance Manager: