

QUALITY CERTIFICATE

№ 2501-104 Issued Date: 17.01.2025

Manufacturer: PlasmaTec LLC
 18 Pravednykiv svitu str., Vinnytsia, Vinnytsia
 region, Vinnytsia district, Ukraine, 21036

Product	
Welding electrodes Monolith 7018-1 H4R TM MONOLITH d 2.5 mm (3/32"): vacuum 2 kg (4.4 LB)	
Specification/Classification	AWS A5.1 / SFA-5.1: E7018-1 H4R CSA W48: E4918-1 H4 EN ISO 2560-A- E 46 5 B 3 2 H5
Batch classification according to EN ISO 14344	C5
Lot Number	001

Mechanical properties of weld metal according to EN 10204, type 2.2

Index	Requirements (AWS A5.1)	Typical data
Tensile strength, (MPa/ksi)	min. 490 (70)	580 (84)
Elongation, %	min. 22	36
Yield strength, (MPa/ksi)	min. 400 (58)	504 (73)
Impact energy (KV), J/(ft-lb) (-50°C/-58°F)	min. 27 (20)	95 (70)
Diffusible hydrogen, ml/100g	max. 4	3.3

Chemical analysis of weld metal, % according to EN 10204, type 3.1

Index	Requirements (AWS A5.1)	Actual data
C	max. 0.15	0.08
Si	max. 0.75	0.6
Mn	max. 1.6	1.37
P	max. 0.035	0.024
S	max. 0.035	0.008
Cr	max. 0.2	0.07
Ni	max. 0.3	0.03
Mo	max. 0.3	0.004
V	max. 0.08	0.01
Mn+Cr+Ni+Mo+V	max. 1.75	1.48

Post weld heat treatment - As welded

The product was manufactured and supplied according to a Quality System Program that meets the requirements of ISO 9001. The delivery conditions are in accordance with EN ISO 544.

Head of Technical Control: Andrii Babyn



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Lot Number identification: **001 3.2 XO** (example of Lot number), where **001** - actual Lot Number, 3.2 XO - additional information (3.2 - electrode size in mm; X - pressing team, O - packing team)