

QUALITY CERTIFICATE

№ 2501-053 Issued Date: 15.01.2025

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

Product
Welding electrodes Monolith M-309L-16 TM MONOLITH d 2.5 mm (3/32"): vacuum 1 kg (2.2 LB)

Specification/Classification	AWS A5.4/ SFA-5.4: E309/E309L-16 CSA W48: E309L-16 EN ISO 3581-A-E 23 12 L R 1 2
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 A5.4)	Typical data
Tensile strength, (MPa/ksi)	min. 520 (75)	579 (84)
Elongation, %	min. 30	36
Ferrite Number, FN (magnetic induction method)	Actual data 5.9	
Ferrite Number, WRC-1992	Actual data 14	



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

Index	Requirements (AWS A5.4)	Actual data
C	max. 0.04	0.01
Si	max. 1.0	0.75
Mn	max. 2.5	1.38
P	max. 0.04	0.023
S	max. 0.03	0.016
Cr	max. 25.0	22.1
Ni	max. 14.0	12.7
Mo	max. 0.75	0.01
Cu	max. 0.75	0.03

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



 quality@plasmatec.com.ua, +380(67)432-19-36 (Viber, WhatsApp, Telegram)

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)