

QUALITY CERTIFICATE

№ 2410-180 Issued Date: 23.10.2024

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 3.1

Index	Requirements (AWS A5.4)	Actual data
Tensile strength, (MPa/ksi)	min. 520 (75)	579 (84)
Elongation, %	min. 30	36
	Requirements (AWS A5.4)	Actual data
Ferrite Number, FN	5 - 15	14.90

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	0.74
Mn	max. 2.5	1.29
P	max. 0.04	0.023
S	max. 0.03	0.022
Cr	max. 25.0	22.5
Ni	max. 14.0	12.78
Mo	max. 0.75	0.02
Cu	max. 0.75	0.05

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.

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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)