

QUALITY CERTIFICATE

№ 2403-087 Issued Date: 09.03.2024

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

Product	
Welding electrodes CI-NiFe TM MONOLITH d 3.2 mm (1/8"): vacuum 1 kg (2.2 LB)	
Specification/Classification	AWS A5.15 / SFA-5.15: E NiFe-CI EN ISO 1071: E C NiFe-CI 3
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 A5.15)	Actual data
Hardness, BHN	165 - 218	203
Tensile strength, (MPa/ksi)	400-579 (58-84)	502 (73)
Yield strength, (MPa/ksi)	296-434 (43-63)	333 (48)
Elongation, %	6 - 18	18

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

Index	Requirements (AWS A5.15)	Actual data
C	max. 2.0	1.26
Mn	max. 2.5	1.39
Si	max. 4.0	0.06
P	N.S.	0.019
S	max. 0.03	0.003
Fe	Rem.	43.64
Ni	max. 60.0	53.28
Cu	max. 2.5	0.2

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)