

QUALITY CERTIFICATE
№ 2403-082 Date: 09.03.2024

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

Product
Welding electrodes Monolith M-309L TM MONOLITH d 3.2 mm: vacuum 1 kg

Specification/ Classification	AWS A5.4/SFA-5.4: E309/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	EN ISO 3581	Typical data
Tensile strength, MPa (N/mm ²)	min. 510	579
Yield strength, MPa (N/mm ²)	min. 320	462
Elongation, %	min. 25	36
Impact energy (KV), J +20°C	min. 60	70/68/70
	EN ISO 3581	Actual data
Ferrite Number, FN	5 - 15	14.9

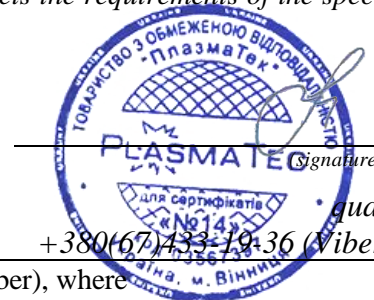
Chemical analysis of weld metal, % according to EN 10204, type 3.1

Index	Requirements	Actual data
C	max. 0.04	0.01
Si	max. 1.00	0.78
Mn	max. 2.50	1.33
P	max. 0.03	0.021
S	max. 0.025	0.019
Cr	max. 25.00	22.60
Ni	max. 14.00	12.67
Mo	max. 0.75	0.04
Cu	max. 0.75	0.07

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 manufacturer guarantees that the product meets the requirements of the specification(s) indicated. 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).