

QUALITY CERTIFICATE

№ 2309-094 Date: 25.09.2023

Manufacturer: PlasmaTec LLC

18 Pravednykiv svitu str., Vinnytsia, Vinnytsia region,
Vinnytsia district, Ukraine, 21036

Product	
Welding electrodes Monolith M-309L TM MONOLITH d 4 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	10.8

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	0.74
Mn	max. 2.50	1.1
P	max. 0.03	0.024
S	max. 0.025	0.023
Cr	max. 25.00	22.4
Ni	max. 14.00	13.7
Mo	max. 0.75	0.018
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 manufacturer guarantees that the product meets the requirements of the specification(s) indicated. 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).