

QUALITY CERTIFICATE

№ 2501-119 Issued Date: 19.01.2025

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

Product
Welding electrodes Monolith 7018-1 H4R TM MONOLITH d 5 mm (3/16"): vacuum 5 kg (11 LB)

Specification/Classification	AWS A5.1 / SFA-5.1: E7018-1 H4R EN ISO 2560-A- E 46 5 B 3 2 H5 CSA W48: E4918-1 H4 4Y46H5
Batch classification according to EN ISO 14344	C5
Lot Number	001

**Mechanical properties of weld metal
EN 10204, type 2.2**

Index	Requirements (AWS A5.1)	Typical data
Tensile strength, (MPa/ksi)	min. 490 (70)	579 (84)
Elongation, %	min. 22	28
Yield strength, (MPa/ksi)	min. 400 (58)	497 (72)
Impact energy (KV), J/(ft-lb) (-50°C/-58°F)	min. 27 (20)	87 (64)
Diffusible hydrogen, ml/100g	max. 4	3.33

**Chemical analysis of weld metal, %
EN 10204, type 3.1**

Index	Requirements (AWS A5.1)	Actual data
C	max. 0.15	0.09
Si	max. 0.75	0.56
Mn	max. 1.6	1.24
P	max. 0.035	0.022
S	max. 0.035	0.008
Cr	max. 0.2	0.06
Ni	max. 0.3	0.03
Mo	max. 0.3	0.004
V	max. 0.08	0.01
Mn+Cr+Ni+Mo+V	max. 1.75	1.344

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)