

QUALITY CERTIFICATE

№ 2308-150 Date: 24.08.2023

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: vacuum 1 kg	
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	002

Mechanical properties of weld metal according to EN 10204, type 2.2

Index	EN ISO 1071	Typical data
Tensile strength, MPa (N/mm ²)	min. 350	502
Yield strength, MPa (N/mm ²)	min. 250	333
Elongation, %	min. 4	21

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

Index	Requirements	Actual data
C	max. 1.80	1.49
Mn	max. 2.50	1.42
Si	max. 1.00	0.08
S	max. 0.03	0.003
P	max. 0.03	0.017
Fe	max. 45.00	44.55
Ni	max. 60.00	52.03
Cu	max. 2.5	0.19

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).