

QUALITY CERTIFICATE

№ **2410-010** Issued Date: **01.10.2024**

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

Product	
Welding electrodes CI-NiFe TM MONOLITH d 4 mm (5/32"): 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	002

Mechanical properties of weld metal according to EN 10204, type 3.1

Index	Requirements (AWS A5.15)	Actual data
Hardness, BHN	165 - 218	217
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	1.31
Mn	max. 2.5	1.62
Si	max. 4.0	0.16
S	max. 0.03	0.003
P	N.S.	0.012
Fe	Rem.	43.91
Ni	max. 60.0	52.6
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 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)