

QUALITY CERTIFICATE

№ 2503-247 Issued Date: 18.03.2025

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

Product
Welding electrodes Monolith M-309L-16 TM MONOLITH d 2.5 mm (3/32"): vacuum 1 kg (2.2 LB)

Specification/Classification	AWS A5.4/ SFA-5.4: E309/E309L-16 CSA W48: E309L-16 EN ISO 3581-A-E 23 12 L R 1 2
Batch classification according to EN ISO 14344	C5
Lot Number	004

Mechanical properties of weld metal EN 10204, type 2.2

Index	Requirements (AWS A5.4)	Typical data
Tensile strength, (MPa/ksi)	min. 520 (75)	555 (80)
Elongation, %	min. 30	46
Ferrite Number, FN (magnetic induction method)	Actual data 6.1	
Ferrite Number, WRC-1992	Actual data 16	

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

Index	Requirements (AWS A5.4)	Actual data
C	max. 0.04	0.01
Si	max. 1.0	0.79
Mn	0.5-2.5	1.11
P	max. 0.04	0.021
S	max. 0.03	0.014
Cr	22.0-25.0	22.9
Ni	12.0-14.0	13.35
Mo	max. 0.75	0.03
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 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)