

QUALITY CERTIFICATE

№ 2311-117 Issued Date: 12.11.2023

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

Product	
Welding electrodes Monolith 7018-1 TM MONOLITH d 4 mm (5/32"): pack 5 kg (11 LB)	
Specification/Classification	AWS A5.1 / SFA-5.1: E7018-1 CSA W48: E4918-1 H8 EN ISO 2560-A-E 46 5 B 3 2 H5
Batch classification according to EN ISO 14344	C5
Lot Number	004

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

Index	Requirements (AWS A5.1)	Actual data
Tensile strength, (MPa/ksi)	min. 490 (70)	561 (81)
Elongation, %	min. 22	31
Yield strength, (MPa/ksi)	min. 400 (58)	465 (67)
Impact energy (KV), J/(ft-lb) (-50°C/-58°F)	min. 27 (20)	84 (62)
Diffusible hydrogen, ml/100g	max. 8	3.7

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

Index	Requirements (AWS A5.1)	Actual data
C	max. 0.15	0.08
Si	max. 0.75	0.64
Mn	max. 1.6	1.45
P	max. 0.035	0.028
S	max. 0.035	0.008
Cr	max. 0.2	0.051
Ni	max. 0.3	0.03
Mo	max. 0.3	0.006
V	max. 0.08	0.01
Mn+Cr+Ni+Mo+V	max. 1.75	1.55

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



quality@plasmatec.com.ua, +380(65)412-19-36 (Viber, WhatsApp, Telegram)

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)