

QUALITY CERTIFICATE

№ 2311-200 Date: 22.11.2023

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

Product	
Welding electrodes Monolith 6010 TM MONOLITH d 4 mm: pack 5 kg	
Specification/Classification	AWS A5.1 / SFA-5.1: E 6010 EN ISO 2560-A-E 42 3 C 21
Batch classification according to EN ISO 14344	C5
Lot Number	005

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

Index	Requirements		Typical data
	(EN ISO 2560-A)	(AWS A5.1)	
Tensile strength, MPa (N/mm ²) / (ksi)	500 - 640	min. 60	574 (83)
Elongation, %	min. 20	min. 22	24
Yield strength, MPa (N/mm ²) / (ksi)	min. 420	min. 48	491 (71)
Impact energy (KV), J -30°C / (-30°C/-20°F)	min. 47	min. 27	60/65/60

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

Index	Requirements (AWS A5.1)	Actual data
C	max. 0.2	0.16
Si	max. 1.0	0.31
Mn	max. 1.2	1.06
Ni	max. 0.3	0.056
Cr	max. 0.2	0.027
Mo	max. 0.3	0.008
V	max. 0.08	0.003
P	N.S.	0.01
S	N.S.	0.003

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.

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).