

QUALITY CERTIFICATE

№ 2311-148 Date: 16.11.2023

Manufacturer: PlasmaTec LLC

18 Pravednykiv svitu str., Vinnytsia, Vinnytsia region,
Vinnytsia district, Ukraine, 21036

| Product | |
|--|---|
| Welding electrodes Monolith 7018-1 H4R TM MONOLITH d 3.2 mm: vacuum 2 kg | |
| Specification/Classification | AWS A5.1 / SFA-5.1: E7018-1 H4R CSA W48 E4918-1 H4 EN ISO 2560-A- E 46 5 B 3 2 H5 |
| Batch classification according to EN ISO 14344 | C5 |
| Lot Number | 008 |

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

| Index | Requirements | | Typical data |
|--|---------------|------------|--------------|
| | (EN ISO 2560) | (AWS A5.1) | |
| Tensile strength, MPa (N/mm ²) / (ksi) | 530 - 680 | min. 70 | 574 (83) |
| Elongation, % | min. 20 | min. 22 | 29 |
| Yield strength, MPa (N/mm ²) / (ksi) | min. 460 | min. 58 | 497 (72) |
| Diffusible hydrogen, ml/100g | max. 5 | max. 4 | 3.5 |
| Impact energy (KV), J (-50°C) / (-45°C/-50°F) | min. 47 | min. 27 | 61/64/62 |

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

| Index | Requirements (AWS A5.1) | Actual data |
|---------------|-------------------------|-------------|
| C | max. 0.15 | 0.09 |
| Si | max. 0.75 | 0.67 |
| Mn | max. 1.6 | 1.47 |
| P | max. 0.035 | 0.025 |
| S | max. 0.035 | 0.007 |
| Cr | max. 0.2 | 0.05 |
| Ni | max. 0.3 | 0.021 |
| Mo | max. 0.3 | 0.005 |
| V | max. 0.08 | 0.01 |
| Mn+Cr+Ni+Mo+V | max. 1.75 | 1.556 |

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



quality@plasmatec.com.ua
+380(67)433-19-36 (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).