

voestalpine Böhler Welding Fileur S.p.A.

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SVETSEKONOMI AB
 RATTVAEGEN 9 - POB 197
 54124 - SKOEVD -
 SVEZIA

Inspection certificate 2.2

as per: EN 10204

No.: 1.571

Rev. 0

Page 1 of 1

PO no.	
Order no.	3732 20/08/14
Delivery note/pos./splitt	
Product	FLUXCORED WIRE
Trade name	R!MAC SJALVSKYDDANDE RORTRAD
Standard designation	EN ISO 17632-A T46 Z Y N1 AWS A5.36 E71T11-AZ-CS3-H8
Dimension	0.8 mm
Heat no.	574008
Quantity	

Chemical composition in % of the product

C	Si	Mn	P	S	Cr	Mo	Ni	V	Cu	Nb	Al	Ti	N	W	B
0,256	0,352	0,772	0,010	0,003	0,03	0,004	0,011	0,003	0,162	0,001	1.583	0,007			0,0001

Mechanical properties**TYPICAL OF ALL WELD METAL EN 10204: 2.2**

Tensile test							according to : EN ISO 6892-1/09	
Specimen preparation							according to : EN 876	
T	ReL / Rp 0,2 MPa	Rp 1,0 MPa	Rm MPa	A (Lo = 5d) %	Z %	WBH PWHT	Remarks	
°C	530		640	24				
Impact test							according to : EN ISO 148-1/10	
Specimen preparation							according to : EN 875 VWT 0/b	
T	Impact energy KV / J	Average KV / J	Lateral expansion mm	Shear fracture %	WBH PWHT	Remarks		
T	Hardness							
°C								

Town
CITTADILLA

Date
03.10.2014

This certificate was issued by DP-equipment and does not require signature.

Authorized representative
RIBAUDO

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Page 1 of 1

PO no.	
Order no.	3732 20/08/14
Delivery note/pos./splitt	
Product	SOLID WIRE
Trade name	R!MAC RF316
Standard designation	AWS A5.9 EN ISO 14343-A ER316LSi G19123LSi
Dimension	0,8 mm
Heat no.	539465
Quantity	

Chemical composition in % of the product

C	Si	Mn	P	S	Cr	Mo	Ni	V	Cu	Nb	Al	Ti	N	W	B
0.011	0,845	1,603	0,016	0,013	18.41	2.55	12.25	0.035	0.093	0.003	0.002				

Mechanical properties

Tensile test							according to : EN ISO 6892-1/09	
Specimen preparation							according to : EN 876	
T	ReL / Rp 0,2 MPa	Rp 1,0 MPa	Rm MPa	A (Lo = 5d) %	Z %	WBH PWHT	Remarks	
°C	>320		>510	>25				
Impact test							according to : EN ISO 148-1/10	
Specimen preparation							according to : EN 875 VWT 0/b	
T	Impact energy KV / J	Average KV / J	Lateral expansion mm	Shear fracture %	WBH PWHT	Remarks		
-196°C	>47							
T	Hardness							
°C								

Town
CITTADELLA

Date
03.10.2014

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RIBAUDO