

Pawlowski GmbH
Industriebedarf-Schweisstechnik
Oggenhauser Hauptstr. 77
89522 Heidenheim
Deutschland

Abnahmeprüfzeugnis 3.1**Inspection certificate 3.1**

nach / as per : EN 10204

Nr. 2018-2091179250-10-18221-014

Rev. 0

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Bestell-Nr.	PO no.	telefonisch	vom / of 12.12.2018
Auftrags-Nr.	Order no.	1091129267	
Lieferschein/Pos./Splitt	Delivery note/pos./splitt	2091179250/000000/000010	vom / of 13.12.2018
Produkt	Product	SG-Drahtelektrode / GMAW wire electrode	201967
Handelsname	Trade name	BOEHLER EMK 8 NC	27487
Normbezeichnung	Standard designation	EN ISO 14341-A - G 46 4 M21 4Si1 / G 46 4 C1 4Si1 AWS A5.18: ER70S-6	3U12G13G 0015
Abmessung	Dimension	1,0 mm 250kg	
Charge	Heat no.	18221	
Liefermenge	Quantity	500,0 KG	

Chemische Analyse in % des Produktes**Chemical composition in % of the product**

C	Si	Mn	P	S	Cr	Mo	Ni	V	Cu	Ti	Al	Zr		
0,07	0,96	1,60	0,009	0,016	0,03	0,01	0,04	< 0,01	0,05	0,01	< 0,01	< 0,01		

Mechanische Gütewerte**Mechanical properties****EN 10204 - 2.2**

Zugversuch		Tensile test					
T	ReL / Rp 0,2 MPa	Rp 1,0 MPa	Rm MPa	A (Lo = 5d) %	Z %	WBH PWHT	Bemerkung Remarks
20°C	≥ 460		530 - 680	≥ 20			M21
Kerbschlagbiegeversuch		Impact test					
T	Kerbschlagarbeit Impact energy KV / J	Mittelwert Average KV / J	Laterale Breitung Lateral expansion mm	Duktiler Bruchanteil Shear fracture %	WBH PWHT	Bemerkung Remarks	
-40°C	≥ 47					M21	

Ort / Town

Hamm

Datum / Date

13.12.2018

Dieses Zeugnis wurde maschinell erstellt und gilt auch ohne Unterschrift.
This certificate was issued by DP-equipment and does not require signature.

Abnahmebeauftragter / Authorized representative

Floer

DATA STAMPA: Stamping Date	7/12/18	CERTIFICATO N°: Certificate number	I22113	VERGELLA: Wire rod	EVO 3	COLATA: Charge	18221	CLIENTE / CUSTOMER PAWLOWSKI GMBH	051362
DDT N°		Vs.Rif.Ord. / Your ref. Nr.		Ns.Rif.Ord. Our ref. Nr.		Quantità (KG) Quantity (KG)		OGGENHAUSER HAUPTSTRASSE,77	
18 BO 004627 18,00		YOUR ORDER 125021 DATED 28/09/2018		18 OC 4337 10,00		1.080,000		89522 HEIDENHEIM OGGENHAUSEN	D

CARATTERISTICHE MECCANICHE TIPICHE DEL DEPOSITO / TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

SECTION 1

Rm N/mm ² Tensile Strength MPa	590	Rs N/mm ² Yeld Strength MPa	500	Al % 5d Elongation Percent	26	KV (J) Impact Test	80(-40°C)	Hardness (HRC)	
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ANALISI CHIMICA COLATA / CHEMICAL ANALYSIS (HEAT)

SECTION 2

C %:	0,073	Si %:	0,968	Mn %:	1,628	P %:	0,007	S %:	0,018	Cr %:	0,022	Mo %:	0,005
Ni %:	0,024	V %:	0,003	W %:		Ti %:	0,0090	Al %:	0,002	Zr %:	0,0001	Sn %:	0,0030
Nb %:		Sb %:		As %:	0,0018	N ppm:	30	O ppm:		Cu* %:	0,037	Fx =	

* = incluso rivestimento / coating included

Fx = (10P + 5 Sb + 4 Sn + As) / 100 (elements in ppm)

CARATTERISTICHE FINALI DEL PRODOTTO / FINAL CHARACTERISTICS OF THE PRODUCT

TIPO: Type	EVO 3	DIAMETRO (mm):	D.1,00	RIVESTIMENTO: Coating	Ramato / Coppered Bronzato / Bronzed X Extra / Non ramato / Uncoppered
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MIG/TIG: **M**

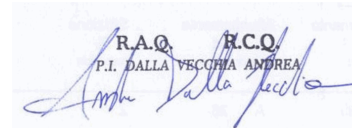
CLASSIFICAZIONI: SFA-AWS A5.18 ER70S-6
Classifications: EN ISO 14341-A- G 46 4 C1/M21 4Si1

Articolo Cliente:
Customer Code:

Member of CISQ Federation

Certified Quality System
According to **UNI EN ISO 9001:2015**
Certificate n° 300/96/S

ITALFIL S.p.A.
Quality Assurance Manager




0045

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DoP n° DM039

DIN EN 13479 + DIN EN ISO 14341

To be used for fusion welding of metallic structures or composite metal and concrete structures in construction works