



professional welding wires

SIDERGAS SPA

Cap. Soc. 1.000.000 € i.v. - C.F. e P. IVA IT00226230233 - www.sidergas.com - e-mail: info@sidergas.com

SEDE LEGALE/CORPORATE: Viale Rimembranza, 17 - 37015 S. AMBROGIO VALP.LLA (VR) - ITALY

SEDE OPERATIVA/PLANT: Via Tombeiolo, 82/A - 37020 DOLCE' (VR) - ITALY

Quality Management System
Certified by TÜV SÜD
complying with the requirements of
UNI EN ISO 9001:15

INSPECTION CERTIFICATE (conforms to EN 10204:04 - 3.1)
Certificato di Collaudo/Abnahmeprufzeugnis/Certificat de Réception

Nr. Lotto/Release No. 19/02768	N° DDT/ Deliv. Note No. 191564	Nr. Fattura/Invoice No. 001005/19C	RQC Marco Martinelli	Nr. Cert./Cert. No. 002518	Data Cert./Cert. Date 24/10/2019
Data Ord./Order Date 15/10/2019	Data DDT/Deliv.Note Date 24/10/2019	Data Fattura/Inv. Date 24/10/2019	Cliente/Purchaser ALUNOX SCHWEISSTECHNIK GMBH		
Nr. Ordine/P.O. No. AX19001888PO	Nr. Container/Container No.:		Destinatario/Consignee		 SIDERGAS S.P.A. 0036 - 08 0036 - CPR - S019 EN 13479:2004
Nr. Sigillo Vettore/Carrier Seal No.	Nr. Sigillo/Seal No. Sidergas		Gießerallee 37a, Postfach 500330 47877 WILLICH (D)		
Vettore/Shipping Agent BARTH-ITALIANA					
Nave/Vessel:	Data Spedizione/Shipping date 25/10/2019				

ANALISI CHIMICA DEL FILO/CHEMICAL COMPOSITION OF THE WIRE

Nr. Colata/ Batch No.:	Normativa/ Standard:	Classificazione/ Classification:	Codice/Part Number Descrizione/Description	Analisi Chimica/Chemical analysis: % p/p/wt.-%																				
				C	Mn	Si	S	P	Cu*	Mo	Ni	Cr	N	V	Al	B	As	Sn	Ca	Ti+Zr	Ti	Zr		
870755	AWS A5.18 CSA W48 EN ISO 14341-A EN ISO-14341-A	ER70S-6 B-G 49A 5 C1 S6 G 42 4 M21 3Si1 G 42 4 M21 3Si1	Code: OC0S6RS12K0150	0,0740	1,4850	0,8970	0,0170	0,0080	0,0510	0,0130														
			Customer P/N: 2251251203																					
			Tradename: SIDERGAS S6																					
			Weight (Kg): 15																					
			Diam. (mm): 1.20	0,0450	0,0510	0,0037	0,0030	0,0020	0,0000	0,0020														
			Finish: VERKUPFERT																					
			Type: K-300	0,0000	0,0000		0,0100	0,0000																
			Winding: LAGE																					
768228	AWS A5.18 CSA W48 EN ISO 14341-A EN ISO-14341-A	ER70S-6 B-G 49A 5 C1 S6 G 46 5 M21 4Si1 G 46 4 M21 4Si1	Code: OC0S7RS08K0150	0,0660	1,6190	0,9760	0,0180	0,0070	0,0450	0,0060														
			Customer P/N: 2251300803																					
			Tradename: SIDERGAS S7																					
			Weight (Kg): 15																					
			Diam. (mm): 0.80	0,0250	0,0240	0,0040	0,0030	0,0020	0,0006	0,0018														
			Finish: VERKUPFERT																					
			Type: K-300	0,0030	0,0000		0,0090	0,0001																
			Winding: LAGE																					
768226	AWS A5.18 CSA W48 EN ISO 14341-A EN ISO-14341-A	ER70S-6 B-G 49A 5 C1 S6 G 46 5 M21 4Si1 G 46 4 M21 4Si1	Code: OC0S7RS10K0150	0,0660	1,6330	0,9700	0,0190	0,0070	0,0480	0,0060														
			Customer P/N: 2251301003																					
			Tradename: SIDERGAS S7																					
			Weight (Kg): 15																					
			Diam. (mm): 1.00	0,0240	0,0300	0,0024	0,0030	0,0020	0,0006	0,0025														
			Finish: VERKUPFERT																					
			Type: K-300	0,0060	0,0000		0,0090	0,0001																
			Winding: LAGE																					
768234	AWS A5.18 CSA W48 EN ISO 14341-A EN ISO-14341-A	ER70S-6 B-G 49A 5 C1 S6 G 46 5 M21 4Si1 G 46 4 M21 4Si1	Code: OC0S7RW10Q3001	0,0660	1,6750	0,9770	0,0190	0,0080	0,0410	0,0040														
			Customer P/N: 22513010055																					
			Tradename: SIDERGAS S7																					
			Weight (Kg): 300																					
			Diam. (mm): 1.00	0,0220	0,0250	0,0027	0,0030	0,0020	0,0007	0,0019														
			Finish: VERKUPFERT																					
			Type: MIDI 300	0,0050	0,0000		0,0090	0,0001																
			Winding: DRALLFREI																					

Note/Remarks: Cu*: Cu di colata/Cu of heat. A questo valore deve essere addizionato l'eventuale rivestimento in rame del filo compreso tipicamente tra 0,5 e 0,15%. / To this value has to be added the copper coating on the wire, if present, typically within the range 0,05 - 0,15%.



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				C	Mn	Si	S	P	Cu*	Mo	Ni	Cr	N	V	Al	B	As	Sn	Ca	Ti+Zr	Ti	Zr			
768234	AWS A5.18 CSA W48 EN ISO 14341-A EN ISO-14341-A	ER70S-6 B-G 49A 5 C1 S6 G 46 5 M21 4Si1 G 46 4 M21 4Si1	Code: OC0S7RW10Q3001	0,0660	1,6750	0,9770	0,0190	0,0080	0,0410	0,0040															
			Customer P/N: 22513010055																						
			Tradename: SIDERGAS S7																						
			Weight (Kg): 300																						
767799	AWS A5.18 CSA W48 EN ISO 14341-A EN ISO-14341-A	ER70S-6 B-G 49A 5 C1 S6 G 46 5 M21 4Si1 G 46 4 M21 4Si1	Code: OC0S7RW12Q5501	0,0740	1,6250	0,9840	0,0180	0,0080	0,0430	0,0140															
			Customer P/N: 2251301255																						
			Tradename: SIDERGAS S7																						
			Weight (Kg): 550																						
872764	AWS A5.18 CSA W48 EN ISO 14341-A EN ISO-14341-A	ER70S-6 B-G 49A 5 C1 S6 G 42 4 M21 3Si1 G 42 4 M21 3Si1	Code: OC0S6RW16Q5501	0,0690	1,4500	0,8560	0,0170	0,0080	0,0760	0,0170															
			Customer P/N: 2251251607																						
			Tradename: SIDERGAS S6																						
			Weight (Kg): 550																						
			Code: OC0S6RW16Q5501	0,0570	0,0490	0,0049	0,0020	0,0020	0,0000	0,0027															
			Customer P/N: 2251251607																						
			Tradename: SIDERGAS S6																						
			Weight (Kg): 550																						
			Code: OC0S6RW16Q5501	0,0000	0,0000		0,0100	0,0000																	
			Customer P/N: 2251251607																						
			Tradename: SIDERGAS S6																						
			Weight (Kg): 550																						

Note/Remarks: Cu*: Cu di colata/Cu of heat. A questo valore deve essere addizionato l'eventuale rivestimento in rame del filo compreso tipicamente tra 0,5 e 0,15%. / To this value has to be added the copper coating on the wire, if present, typically within the range 0,05 - 0,15%.