



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

PRODUCT CERTIFICATE (conforms to EN 10204)
Certificato di Prodotto/Certificat de Produit

NrLotto/Release N° 21/00634 Data Ord./Order Date 02/03/2021	N° DDT/ Deliv. Note No. 210465 Data DDT/Deliv.Note Date 25/03/2021	NrFattura/Invoice N° 000272/21C DataFattura/Invoice Date 25/03/2021	RQC Marco Martinelli	Nr. Cert./Cert. No. 000723	Data Cert./Cert. Date 25/03/2021
Nr. Ordine Acq. / P.O. No. VARI			Nr. Container/Container No.		
Nr. Sigillo Vettore/Seal N°			Nr. Sigillo/Seal N° Sidergas		
Vettore/Shipping Agent: BARTH-ITALIANA			Destinatario/Consignee Hans-Guenther-Sohl-Str. 1 47807 KREFELD (D)		
Nave/Vessel:			Data Spedizione/Shipping date: 29/03/2021		
SIDERGAS S.P.A.  0036 - 06 0036 - CPR - S019 EN 13479:2017					

ANALISI CHIMICA DEL FILO/CHEMICAL COMPOSITION OF THE WIRE
in accordo a/according to EN 10204 3.1

Nr.Colata/ Batch No.	Normativa/ Standard:	Classificazione/ Classification:	Codice/P. Number Des.ne/Description	Analisi Chimica/Chemical analysis: % p/p/wt.-%						
				C	Mn	Si	S	P	Cu*	Mo
976954	EN ISO 14341-A AWS A5.18 CSA W48 EN ISO-14341-A	G 46 5 M21 4Si1 ER70S-6 B-G 49A 5 C1 S6 G 46 4 M21 4Si1	Code: OC0S7RW10Q3001	0,0670	1,6340	0,9730	0,0160	0,0090	0,0300	0,0060
			Customer P/N: 22513010055	0,0260	0,0360	0,0060	0,0030	0,0020	0,0006	0,0022
			Tradename: SIDERGAS S7	0,0000	0,0000	0,0110	0,0013			
			Diam. (mm): 1.00							
			Weight (Kg): 300							
			Finish: VERKUPFERT							
			Type: MIDI 300							
			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%.

CARATTERISTICHE MECCANICHE DEL METALLO SALDATO / MECHANICAL PROPERTIES OF ALL-WELD METAL
in accordo a/according to EN 10204 2.2

Resistenza a trazione / Tensile Strength:		Snervamento (0,2%)/ Yeld Strength (0,2%)		Allungamento / Elongation:	Resilienza / IMPACT TEST (KV)		
	(MPa)		(MPa)		Temperatura/Temp.	media (J) / average (Lb x Ft.)	
600		500		26,00 (%)	-20°C -4°F	80	59
					-50°C -58°F	57	42
86.958	(PSI)	72.465	(PSI)				

Note/Remarks:

Metallo Base/Base Materials: S 355J2 N EN 10025-2
Campioni/Specimens: TENSILE TEST according to EN ISO 5178 / EN ISO 6892-1 diam. 10mm area 78,5 mm2 - longt. all weld metal at 1/2 thk;
Campioni/ Specimens: IMPACT TEST according to EN ISO 9016 / EN ISO 148 10x10 mm area 80mm2 - test pieces taken at mid-depth of weld.
Gas di Protezione/Protection Gas: EN ISO 14175 M21
Trattamenti Termici/Heat Treatments: TEST CARRIED OUT IN "AS WELDED CONDITION"

Note Certificato / Certificate Remarks:

The content of Diffusible hydrogen in deposited metal welded with our welding wires, in accordance with the Standard EN 1011-2:2001, meets the Hydrogen Scale D as shown on the table C.2 - Hydrogen Scales at page 17 of EN 1011-2:2001 paragraph C.2.3.2 Hydrogen Scales.

- This certificate is produced electronically and is valid without signature - We certify that the filler is made in Italy by SIDERGAS SPA according to above normatives and to order prescriptions, and in compliance with a certified ISO 9001 Quality Assurance System