

Delivery note no.: 80222872

Customer: Pawlowski Industriebedarf
 Oggenhauser Hauptstr. 77
 89522 Heidenheim - Oggenhausen

Customer order no.: BE24IGH60342

Quantity delivered: 480,00 KG
 Customer: (to be filled in by customer)

Certificate no.: WZ22S/71013A/014601/80222872-10

Quantity delivered: (to be filled in by customer)

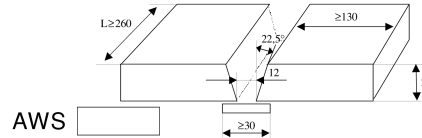
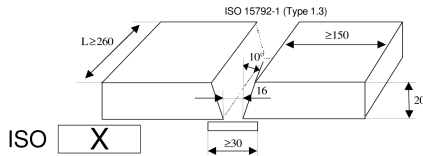
Type: **MEGAFIL 710 M**
 Diameter Ø: **1.2 mm | 0.045"**
 Batch: **014601**

Specification: T 46 6 M M21 1 H5
 ISO 17632 A: E70C-6M H4
 AWS A5.18:

Current: =+/DCEP 240 A
 Voltage: 27 V
 Welding speed: 35 cm/min
 Shielding gas / Flux: M21(82/18)
 Flow rate: 15 l/min
 Stick out: 15-20 mm
 Position: PA (1G)
 Interpass temp.: 150 °C 302 °F

DB-type certificate: 42.027.05
 TÜV-type certificate: 07605

Test methods



EN 10204 - 3.1: All weld metal chemical composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	V	Ti	Nb	N2
0,05	0,68	1,35	0,009	0,005	0,019	0,012	0,001	0,144	0,002	0,004	0,016	0,006	0,006
ISO													
		max.			max.	max.	max.	max.		max.		max.	
		2,00			0,20	0,50	0,20	0,30		0,08		0,05	
AWS													
max.	max.	max.	max.	max.	max.	max.	max.	max.		max.			
0,12	0,90	1,75	0,03	0,03	0,20	0,50	0,30	0,50		0,08			

EN 10204 - 2.2: Mechanical properties of the pure weld metal (typical values)

Heat-treatment	Tensile test ISO 5178			Impact test ISO 9016 VWT 0/b									
	Rm [MPa]	Rp0,2 [%]	A [%]	RT	0°C	-20°C	-40°C	-60°C	RT	32°F	-4°F	-40°F	-76°F
as welded	600	530	27										
	min. 530	min. 460	min. 20										
	[ksi]	[ksi]	[%]				140	100				103	74
	min. 77	min. 67	min. 20										

Name: Jutzi
 Date: 07.03.2024

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