

INE INDUSTRIA NAZIONALE ELETTRODI S.p.A.

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R.E.A. Padova N. 56139
Reg. Naz. AEE IT0802000001408



Inspection Certificate

138047

Type INEFIL

Client 301574

DANTEK ELEKTRO

SMEDELOKKEN 10
5330 MUNKEBO

DENMARK

INE Order No. 941 Dated 4/02/2016

Customer Ref. 23424 DD 2.4.16

Norms

AWS A 5.18 ER 70S-6

EN ISO 14341-A: G 46 4 M21 3Si1

EN ISO 14341-A: G 42 2 C1 3Si1

Reference:

C	Si	Mn	S	P	Cu	Ni	Cr	Mo	Al	V	Zr+Ti
,060	,800	1,400	,000	,000	,000	,000	,000	,000	,000	,000	,000
,130	1,000	1,600	,025	,025	,300	,150	,150	,150	,020	,030	,150

SECTION 1

CHEMICAL COMPOSITION WIRE:

Heat Number : 2878/P

Batch/Lot Number : 161315

Diam. : mm 0,80

C	Si	Mn	S	P	Cu	Ni	Cr	Mo	Al	V	Zr+Ti	N
,075	,811	1,400	,010	,013	,149	,032	,056	,002	,008	,001	,003	,010

SECTION 2

MECHANICAL PROPERTIES WELD METAL

Property	Unit	Requirement	Result
Tensile strength	Rm	530- 680 MPa	560
Yield strength	Rs	>= 460 MPa	470
Elongation	A5d	>= 22,0 %	26,0
Charpy V-Notch at 40- C°	Kv	>= 47 Joule	80
Hardness	HRc	>= HRc	

We certify that this product is made in Italy by INE Spa and is in accordance with the above norms.
Radiographic test by Xray: Satisfactory.

Cittadella, 26/02/2016

Signature
I.N.E. S.p.A.
Industria Nazionale Elettrodi

Conforms To ASME II, Part C, SFA 5.01, Schedule F, Class S3
Document according to UNI EN 10204/2005 - SECTION 1:par.3.1
SECTION 2:par.2.2

During the manufacturing processes, examinations and tests, the material did not come in direct contact with mercury or any of its compounds, nor with any mercury containing device employing a single boundary of containment.

The radioactivity of the heat is less than 100 Becquerels per kilogram.

Material manufactured in accordance with Quality Assurance Manual Reference : INE Edition 04 dd 10 June 2014

This certificate is electronically generated and valid without signature.

