

INE INDUSTRIA NAZIONALE ELETTRODI S.p.A.

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R.E.A. Padova N. 56139
Reg. Naz. AEE IT08020000001408



Inspection Certificate 135907

Type INE SUPER Client 301574 DANTEK ELEKTRO
SMEDELOKKEN 10
5330 MUNKEBO DENMARK

INE Order No. 49402 Dated 6/10/2015

Customer Ref. ON 23137 DD 6.10.15

Norms
AWS A5.1 E 6013 EN ISO 2560-A: E 42 0 RC 11

Reference:

C	Si	Mn	S	P	Cu	Ni	Cr	Mo	V	Nb
,000	,200	,200	,000	,000	,000	,000	,000	,000	,000	,000
,120	,600	,700	,030	,030	,300	,300	,200	,150	,050	,050

SECTION 1
CHEMICAL COMPOSITION WELD METAL:

Heat Number : 9793

Batch/Lot Number : .

Diam. : mm 3,20

C	Si	Mn	S	P	Cu	Ni	Cr	Mo	Al	V	Nb
,068	,312	,389	,018	,015	,075	,067	,046	,011	,006	,004	,002

SECTION 2
MECHANICAL PROPERTIES WELD METAL

				RESULT
Tensile strength	Rm	500-	640 MPa	540
Yield strength	Rs	>=	420 MPa	460
Elongation	A5d	>=	20,0 %	23,0
Charpy V-Notch at 20 C°	Kv	>=	47 Joule	60
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, 12/01/2016

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.

