



**Certificate of Conformance
to Requirements for Welding Electrode
EN 10204 3.1**

Customer :			
Product : SWX 150	Customer P.O.# : 2000-007182/PO:ICO-01324097	Certificate No. : F022624-5	
Lot No. : 240205	Mesh Size :	Date of Mfg. : 02/05/2024	
Specification : --	Classification : --	Date of Issue : 02/26/2024	

CHEMICAL ANALYSIS OF FLUX FOR SUBMERGED ARC WELDING

SiO ₂	12.7%
Al ₂ O ₃ + TiO ₂	18.2%
MnO + FeO	0.84%
CaO + MgO + CaF ₂	68.0%



J. M. WANG
Q.C Section J. M. WANG

Manufacturing, Certification and Limited Warranty Agreement

Data for the above supplied product are those obtained when welded and tested accordance with the above specification. All tests for the above classification were satisfied. Other tests and procedures may produce different results. The above supplied product are manufactured by Tien Tai Electrode an ITW Co. located at: No.6 Kaifa 4th Rd., Rende Dist., Tainan City 717, Taiwan R.O.C. Hobart Brothers produces welding consumables under continuing quality assurance programs audited and approved by Lloyd's Register Quality Assurance Limited(LRQA)



Certificate No. :B022624-1

**Certificate of Conformance
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EN 10204 3.1**

Customer :

Product : SDX S3Si-EH12K/SWX 150
 Diameter : 4.0mm
 Classification : F7A8-EH12K
 Specification : AWS A5.17-'19

Customer P.O.# : 2000-007182/PO:ICO-01324097
 Lot No. : 12418/2019;240205
 Date Tested : 02/19/2024
 Date of Issue : 02/26/2024

Part Number :
 Lot Classification :
 Level of Testing :

Test Settings

Amps DCEP	Volts	WFS	Shielding Gas	Electrode Stickout	Temperature		Travel Speed
					Preheat	Interpass	
500	28	43 ipm	NONE	35 mm	85±25 °F 30±15°C	300±25 °F 150±15 °C	16±1 ipm

6 Layers, 2 passes on each layer 1 through 6; 7th Layer, 3 passes on cap layer; Direction reversed on each layer.

Mechanical Properties Lab Test #2DB19

Shielding Gas	Testing Conditions	Ult. Tensile Strength	Yield Strength	Elong % in 2 "	Impact Test Temp.	Charpy V-Notch Values ft.lbf		
NONE	AS WELDED	80075 psi 552 MPa	67559 psi 466 MPa	32	-80 °F -62 °C	64 Average	88 85	101 (115 J)

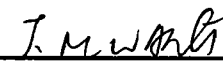
Radiographic		Fillet Weld Test					Moisture %	
Inspection:	Conforms	Horizontal:	N/A	Vertical:	N/A	Overhead:	N/A	N/A
Bending Test								

Chemical Composition of Wire and Rod (%)

Elements	C	Mn	Si	S	P	Cu								
Filler Metal	0.09	1.57	0.32	0.004	0.011	0.050								

Remarks

Production Date :02/05/2024


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