



INSPECTION CERTIFICATION

According to EN 10204 3.1

Client	SWP	Heat No.	6781	Date of Delivery	Dec., 27, 2024
Products	SUPER 6SG2	Test No.	836781	Date of Production	Dec., 2024
Order no.	45398	Size	1.0mm(7308)	Date of Test	Dec., 13, 2024

All-weld-metal/Chemical analysis(%)-CO2/MIXED GAS

C	Si	Mn	P	S	Cr	Ni	Mo	V	Al	Ti+Zr	Cu
0.09	0.89	1.58	0.013	0.012	0.009	0.006	0.005	0.003	0.002	0.03	0.22

Welding conditions

Current type	DC+	Arc voltage(V)	22-26	Inter pass temp.	150
Current(A)	220-260	Shielding Gas	EN ISO 14175-C1,M20,M21		

All-weld-metal mechanical properties

Tensile test									
Test no.		Heat treatment	Tensile strength(MPa)		Yield Strength(MPa)		Elongation(%)		
836781		-	547		458		28		
Impact test									
Test no.	Notch type	Test temperature	Shielding Gas	Impact value(J)					Average
				1	2	3	4	5	
836781	V	-40	M21	97	99	98	96	97	97.40
836781	V	-40	C1	85	84	83	83	85	84.00
Radiography			Bending test(Butt Weld)			Hydrogen Test			
II			OK			2.78			



Standard no.: AWS A5.18 ER70S-6

EN ISO 14341-A-G 42 4C1/M21 3Si1

DIN 8559 SG2

0036

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DOP Ref.:Super 6 SG2 2024-001

EN13479:2017

Approvals: TÜV SÜD

CPR Certificate no.:0036-CPR-S 128.2020.004

We hereby certify that the product described above "complies with the term of the order" and conforms with the related international standards"

Inspecting Department : QC Department

Inspector : **Gary Waterman**

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