

Inspection Certificate 3.1



EN 10204

Chemical ☐ 2.2 ☐ 3.1
Mechanical ☒ ☐

Customer	MULTIWELD BV RIGA 3 LW BARENDRECHT (NL) The Netherlands		
Order Nr	522-88407327-010		
Product group	GMAW/GTAW Wire – Non & Low alloyed		
Brand name	Mulax SG3 ER70 S-6, BS-300 PLW 15 kg		
Article nr	MD20.03.31508		
Standard	ASME Section IIC SFA/AWS A5.18:05	TS EN ISO 14341-A:11	
Classification	ER 70 S-6	G46 4 M21/C1 4Si1	
Size	0,80mm		
Quantity	3.240 KG		
Serial Nr	21333233		
Charge Nr	21333233		

Chemical Composition of Weld Metal (%)

Charge Nr	C	Si	Mn	P	S	Cr	Ni	Mo	Cu*	V	Al	Ti+Zr
AWS	0,06-0,15	0,80-1,15	1,40-1,85	<0,025	<0,035	<0,15	<0,15	<0,15	<0,50	<0,03	-	-
TS/EN/ISO	0,06-0,14	0,80-1,20	1,60-1,90	<0,025	<0,025	<0,15	<0,15	<0,15	<0,35	<0,03	<0,02	<0,15
21333233	0,087	0,897	1,731	0,010	0,008	0,025	0,029	0,001	0,047	0,003	0,003	0,002

*Including the copper coating

Mechanical Properties

Tensile Test		EN ISO 6892-1			Impact Test			EN ISO 148-1:2010		
Specimen preparation		EN ISO 5178:2011			Specimen preparation			EN ISO 9016:2011		
	Test Temp.	Rp Yield Strength	Rm Tensile Strength	A Elong.	Test Temp.	KV Impact Strength	KV Average	Hardness	Radiographic test	Comment
	°C	N/mm ²	N/mm ²	%Lo=5d0	°C	J	J	-	-	-
AWS	20	≥400	≥480	≥22	-30	-	≥27	-	-	-
TS/EN/ISO	20	≥460	530-680	≥22	-40	-	>47	-	-	-
	20	Min 460	540-670	Min 22	-40	-	Min 47	-	-	-

Remarks:

Date 12-8-2022
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Customer Care