Date: May 29, 2015

PRODUCT DATA SHEET

WeldWire Company, Inc.
103 Queens Drive
King of Prussia, PA 19406

Product: WW71T-1C/1M H8

Classification: E71T-1, E71T-1C, E71T-1M H8

Specification: AWS A5.20/A5.20M:2005, ASME SFA 5.20/SFA 5.20M

This is to certify that the product named above shall meet the requirements of the Specification, AWS A-5.20 / A5.20M: 2005. The product is of the same classification, manufacturing process and material requirements as the material which was used for the test purposes, the results are given below.

CHEMICAL ANALYSIS % ALL-WELD METAL

C	Si	Mn	P	S	Ni	Cu	Cr	Mo
0.12 max	0.90 max	1.75 max	0.03 max	0.03 max	0.50 max	0.35 max	0.20 max	0.30 max
0.035	0.60	1.25	0.013	0.007	0.04	0.06	0.04	0.006

MECHANICAL TESTING RESULTS (in the as-welded condition)

Tensile Strength MPa (ksi)	Yield Strength MPa (ksi)	Elongation (%)	CVN Results, J at -20°C (ft-lb@0°F)
490-670 (70-95)	390 (58 Min)	22 Min	27 J Min(20 ft-lb Min)
593 (86.1)	506 (73.4)	26.4	58J (42.8ft-lb)

RADIOGRAPHIC TEST	FILLET WELD TEST: ASME II PART C SFA 5.20
Meets Requirements	Meets Requirements

WELD METAL DIFFUSIBLE HYDROGEN: (ml/100g) by Gas Chromatography method per AWS A4.3-93

≤ 8.0ml/100g Gr. (N=5)

WELDING CONDITIONS

Size	Polarity	Voltage (V)	Current (A)	Wire Feed	Preheat	Interpass	Shielding Gas
.045	DC (+)	24	200	300 in/min	20°C (70°F)	150°C (300°F)	75%Ar + 25%CO_2
.045	DC (+)	27	200	300 in/min	20°C (70°F)	150°C (300°F)	100%CO_2
1/16	DC (+)	24	200	200 in/min	20°C (70°F)	150°C (300°F)	75%Ar + 25%CO_2
1/16	DC (+)	26	250	200 in/min	20°C (70°F)	150°C (300°F)	100%CO_2

Country of Origin: USA