



MILL TEST CERTIFICATE

EN 13479:2004

OUR INV. (REF.) NO. 2537	DATE OF ISSUE Aug 24,2024	CERT. NO. 2408143
PRODUCED BY: ESSETI NEW ZEALAND LIMITED	CONFORM TO: AS/NZS EN ISO:17632-A T42 2 P M/C 1 H4 AS/NZS EN ISO 17632-B T49 2 T1-1CA H4 AWS A5.20 E71T-1C/M H4 AWS A5.36 E71T1-M21/C1A2-CS1-H4 DIN EN ISO 17632-A-T 42 2 P C 1 H4	
CONSIGNED TO: WELDING TECHNOLOGY	APPROVED BY: DB TÜV- under gas C1 DIN EN439	
TRADE MARK: XCEL	CCS (3YSH15 under gas C1) LR (3YSH15 under gas C1) DNV.GL (III YMSH10 under gas C1) ABS (3YSAH10 under gas C1)	
PRODUCT: Mild Steel Flux Cored Wires For Gas Shield Arc Welding	Welding Position: PA, PB, PC, PD, PE, PF,PG DIN EN ISO6947	

PART NO.	BATCH NO.	DIA./PACK	NET WEIGHT		MFG. DATE
WT-XFC72H41215	24-0638	1.2mm*15KG	8640	KGS	Aug 16TH, 2024
WT-XFC72H41615	24-0639	1.6mm*15KG	2160	KGS	Aug 16TH, 2024

CHEMICAL COMPOSITION OF DEPOSITED METAL										ACUTAL VALUES ACC. EN10204 3.1
REQUIREMENT	C	Si	Mn	P	S	Ni	Cr	Mo	V	
	≤0.18	≤0.90	≤2.0	≤0.03	≤0.03	≤0.5	≤0.2	≤0.3	≤0.08	
BATCH NO										
24-0638	0.06	0.33	1.42	0.011	0.0080	0.01	0.02	0.005	0.01	
24-0639	0.07	0.35	1.37	0.012	0.0110	0.005	0.008	0.004	0.01	

MECHANICAL PROPERTIES OF DEPOSITED METAL								
STANDARDS	TENSILE STRENGTH (MPa)	YIELD STRENGTH (MPa)	ELONGATION (%)	IMPACT VALUE (J @ -20°C)		X-RAY TEST	BEND TEST Face/Back/Side	
	490-670	≥400	≥22	≥54		I	OK	
BATCH NO.								
23-0114	564	492	26.5	120	118	125	I	OK
23-0114	560	485	27	116	119	120	I	OK

REPORTED STRENGTH VALUES ARE STATISTICAL DATA DERIVED FROM ROUTINE TESTING OF THE ITEM IN QUESTION.

DIFFUSIBLE HYDROGEN CONTENT (ml/100g) **3.84**

THIS IS TO CERTIFY THAT ABOVE LISTED PRODUCTS WERE MANUFACTURED TO MEET THE CLASS T4 REQUIREMENT OF AWS A5.01 AS REQUIRED BY CLAUSE 6.3.1.1 OF AWS D1.8/D1.8M: 2005

THIS PRODUCT SATISFIES THE REQUIREMENTS OF AWS D1.8/1.8M:2005, ANNEX E AFTER EXPOSURE FOR TWO WEEKS AT 27°C, 80% RELATIVE HUMIDITY

This is to certify that the welding consumable conforms to the above standards.

ISSUED BY:

FUNCTION:

QA MANAGER

DATE:

Aug 24,2024