

# CERTIFICATE OF QUALITY



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Province. Jiangsu, China

**Kunshan Gintune Welding Co.,LTD.**

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Trade Name	Xcel-Are E70C-6M (XMC-70M)	Size	1.2 mm	Mfg.Date	Jun 10, 2021	
Lot No.	E61128F	Specification	AWS A5.18-2017 E70C-6M (ASME SFA5.18-2019 E70C-6M) (ISO 17632-2015 A-T42 4 M M21 1) (ISO 17632-2015 B-T49 4 T15-1 M21 A)			
Customer		Date of Issue	Jul 09, 2021	Certificate No.	CZ2170560	

### Chemical Composition (%)

Elements	C	Si	Mn	P	S	Cr	Mo	Ni	Cu	V	Fe			
Requirement	Max. 0.12	Max. 0.90	Max. 1.75	Max. 0.03	Max. 0.03	Max. 0.20	Max. 0.30	Max. 0.50	Max. 0.50	Max. 0.08	--	--	--	--
Deposited Metal	0.063	0.65	1.40	0.007	0.013	0.02	0.004	0.01	0.01	0.001	--	--	--	--

### Mechanical Properties

Test Name	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Radiographic Test	Impact Test	
					Test Temp (°C)	Absorbed Energy (J)
Requirement	400 Min.	490 Min.	22 Min.	I	-30	27 Min.
Test Value	466	568	29	I	-40	53/63/67 AVE:61

Bending Test			Fillet Weld Test	Hardness Test	Ferrite	Moisture (%)	Diffusible Hydrogen (ml/100g)	Mn+Ni+Cr+ Mo+V= (%)	Heat No.
Side	Face	Root							
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### Welding Condition

Type of Current	Amperage(A)	Voltage(V)	Shielding Gas
DCEP	250	28	80%Ar+20%CO2
Electrode Stickout (mm)	Preheat Temp.(°C)	Interpass Temp.(°C)	PWHT
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### Certified

REMARKS

We hereby certify that this report is correct and that all test results are in compliance with the specification described herein.

