

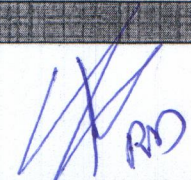
Product Certificate

General Information		
Customer : نورد و لوله قائم	Date : 1401/11/27	Cert. No. : 1401 - 1466

Product Information		
Consumables	Classification	Welding Method
Flux : KJF - 610	EN 760 : S A A B 1 6 8 A C	SAW <input checked="" type="checkbox"/> FIFO <input type="checkbox"/>
Wire : KJS - 120	EN 756 : S2	GMAW <input type="checkbox"/> FCAW <input type="checkbox"/>
		SMAW <input type="checkbox"/> GTAW <input type="checkbox"/>
Flux	Product No. : 8112880811	
Wire	Diameter : 4.0 mm	Product No.: ---

Chemical Composition %						
Wire Chemical Composition %						
Heat No.	C	Si	Mn	S	P	Cu
120245	0.09	0.08	0.89	0.01	0.02	0.10
All Weld Metal Chemical Composition %						
C	Si	Mn	S	P	Cu	
0.04	0.33	1.48	0.02	0.01	0.05	

Mechanical Properties for All Weld Metal				
Tension Test				
Condition	Test Temp . (° C)	U . T . S . (N / mm ²)	Y . S . (N / mm ²)	EL %
As welded	R.T.	544	462	27.5
Charpy V - Notch Impact Test				
Test Temp . (° C)	No.1	No.2	No.3	Average (joules)
-30	60	56	51	55.7

Additional information


Contact Us	IPOC Supervisor	Quality Control Manager
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