



Commercial Kitchen Equipment Parts

HOBART AWS

Hobart AWS document

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Product: FabCO RXR
Diameter: 1/16"
Shielding Gas: C1 (100% CO2)
Current/Polarity: DCEP
Classification: E70T-1, E70T-9
Specification: AWS A5.20/A5.20M:2005
Test Completed: 8/08/2019

Certificate of Conformance

For AWS D1.8/D1.8M, Seismic Supplement

This is to certify that the product named is of the same classification, manufacturing process, and material requirements as the material, which was used for the test which was concluded on the date shown, the results of which are shown below. All test required by the code or specifications were performed at that time and the material tested met all requirements. The product was manufactured and supplied by the Quality System Program of Hobart Brothers, which meets the requirements of ISO 9001:2015, ANSI/AWS A5.01, and other specification and Military requirements, as applicable.

Test Settings	High Heat Input	Low Heat Input	Lot- # C000671202441	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.1 kJ/in	28.7 kJ/in	Mechanical Properties		79.1 kJ/in	28.7 kJ/in
			Test Reference #		PD8033	PD8041
Voltage	32	28	Tensile Strength (psi)	70,000	92,100	98,700
Current (amps)	400	250	Yield Strength (psi)	58,000	77,800	88,200
WFS (ipm)	420	210	Elongation (%)	22	27	23
Travel Speed (ipm)	9.7	14.6	Average Charpy V-notch			
Stick Out	3/4"	3/4"	Impact Properties ft•lbs @ +70 °F	40	64	44
# of passes	8	20				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # Z020301601432	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.5 kJ/in	29.4 kJ/in	Mechanical Properties		81.5 kJ/in	29.4 kJ/in
			Test Reference #		PD1897	PD1961
Voltage	32	28	Tensile Strength (psi)	70,000	86,800	100,000
Current (amps)	400	250	Yield Strength (psi)	58,000	71,900	94,400
WFS (ipm)	400	210	Elongation (%)	22	29	23
Travel Speed (ipm)	9.4	14.3	Average Charpy V-notch			
Stick Out	3/4"	3/4"	Impact Properties ft•lbs @ +70 °F	40	79	65
# of passes	7	23				
# of layers	4	8				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # V018271208323	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	81.3 kJ/in	29.6 kJ/in	Mechanical Properties		81.3 kJ/in	29.6 kJ/in
			Test Reference #		PC0789	PC0802
Voltage	32	28	Tensile Strength (psi)	70,000	87,300	102,000
Current (amps)	398	259	Yield Strength (psi)	58,000	71,200	94,600
WFS (ipm)	400	208	Elongation (%)	22	28	23
Travel Speed (ipm)	9.4	14.7	Average Charpy V-notch			
Stick Out	3/4"	3/4"	Impact Properties ft•lbs @ +70 °F	40	63	54
# of passes	7	21				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Diffusible Hydrogen - Tested in accordance with AWS A5.20/A5.20M, Clause 16 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	C000671202441	HB3075	3.3 (ml/100g)
7 Day Exposure	C000671202441	HB3173	7.6 (ml/100g)

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David A. Thomas, Quality Assurance Representative



Product: FabCO RXR
Diameter: 3/32"
Shielding Gas: C1 (100% CO2)
Current/Polarity: DCEP
Classification: E70T-1, E70T-9C
Specification: AWS A5.20/A5.20M:2005
Test Completed: 2/12/2019

Certificate of Conformance

For AWS D1.8/D1.8M, Seismic Supplement

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Test Settings	High Heat Input	Low Heat Input	Lot- # B018031013852	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	84.4 kJ/in	37.8 kJ/in	Mechanical Properties		84.4 kJ/in	37.8 kJ/in
			Test Reference #		PD7170	PD7135
Voltage	34	27	Tensile Strength (psi)	70,000	92,000	97,000
Current (amps)	550	350	Yield Strength (psi)	58,000	77,000	89,000
WFS (ipm)	240	125	Elongation (%)	22	27	24
Travel Speed (ipm)	13.3	15	Average Charpy V-notch			
Stick Out	1"	1"	Impact Properties ft•lbs @	40	54	66
# of passes	7	14	+70 °F			
# of layers	4	6				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # Z002191114072	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	80.1 kJ/in	37.8 kJ/in	Mechanical Properties		80.1 kJ/in	37.8 kJ/in
			Test Reference #		PD0546	PD0535
Voltage	34	27	Tensile Strength (psi)	70,000	90,000	99,000
Current (amps)	550	350	Yield Strength (psi)	58,000	74,000	92,000
WFS (ipm)	225	125	Elongation (%)	22	26	23
Travel Speed (ipm)	14	15	Average Charpy V-notch			
Stick Out	1"	1"	Impact Properties ft•lbs @	40	70	60
# of passes	8	14	+70 °F			
# of layers	4	6				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # T047781112061	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	79.4 kJ/in	37.3 kJ/in	Mechanical Properties		79.4 kJ/in	37.3 kJ/in
			Test Reference #		PB9039	PB9202
Voltage	34	27	Tensile Strength (psi)	70,000	90,000	102,000
Current (amps)	549	350	Yield Strength (psi)	58,000	75,000	94,000
WFS (ipm)	225	125	Elongation (%)	22	26	23
Travel Speed (ipm)	14.1	15.2	Average Charpy V-notch			
Stick Out	1"	1"	Impact Properties ft•lbs @	40	67	54
# of passes	8	14	+70 °F			
# of layers	4	6				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	1G	1G				

Diffusible Hydrogen - Tested in accordance with AWS A5.20/A5.20M, Clause 16 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	B018031013852	HB2949	6.4 (ml/100g)
7 Day Exposure	B018031013852	HB2995	5.8 (ml/100g)

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