

QUALITY CERTIFICATE

№ **2502-014** Issued Date: **02.02.2025**

Manufacturer: PlasmaTec LLC

**18 Pravednykiv svitu str., Vinnytsia, Vinnytsia
region, Vinnytsia district, Ukraine, 21036**

Product
Welding electrodes Monolith 7018-1 TM MONOLITH d 3.2 mm (1/8"): pack 2.5 kg (5.5 LB)

Specification/Classification	AWS A5.1 / SFA-5.1: E7018-1 CSA W48: E4918-1 H8 EN ISO 2560-A-E 46 5 B 3 2 H5
Batch classification according to EN ISO 14344	C5
Lot Number	001

Mechanical properties of weld metal EN 10204, type 2.2

Index	Requirements (AWS A5.1)	Typical data
Tensile strength, (MPa/ksi)	min. 490 (70)	561 (81)
Elongation, %	min. 22	31
Yield strength, (MPa/ksi)	min. 400 (58)	465 (67)
Impact energy (KV), J/(ft-lb) (-50°C/-58°F)	min. 27 (20)	84 (62)
Diffusible hydrogen, ml/100g	max. 8	3.7

Chemical analysis of weld metal, % EN 10204, type 3.1

Index	Requirements (AWS A5.1)	Actual data
C	max. 0.15	0.08
Si	max. 0.75	0.68
Mn	max. 1.6	1.45
P	max. 0.035	0.024
S	max. 0.035	0.008
Cr	max. 0.2	0.08
Ni	max. 0.3	0.04
Mo	max. 0.3	0.004
V	max. 0.08	0.01
Mn+Cr+Ni+Mo+V	max. 1.75	1.58

Post weld heat treatment - As welded

The product was manufactured and supplied according to a Quality System Program that meets the requirements of ISO 9001. The delivery conditions are in accordance with EN ISO 544.

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Lot Number identification: 001 3.2 XO (example of Lot number), where **001** – actual Lot Number, **3.2 XO** - additional information (3.2 - electrode size in mm; X – pressing team, O - packing team)