



Inspectiecertificaat (3.1) - Chemische analyse  
Testrapport (2.2) - Mechanische eigenschappen  
INSPECTION CERTIFICATE (3.1) - Chemical analysis  
TEST REPORT (2.2) - Mechanical properties

Datum/Date: 2023-06-24

Certificaat nummer/Cert no: EC27197561 rev. 0

ESAB ordernummer/Our order: 0100800175  
ESAB referentie/Our ref: M3PRD020  
Klantnummer/Cust no: NLB00033  
Orderdatum/Your date: 20230622

Ordernummer/Your order: 20031814567  
Referentie/Your ref:  
Faxnummer/Your fax:  
E-mail adres/Your e-mail:

Faktuuradres/Invoice address  
ZEVU BV LASAULEC HEERENVEEN  
POSTBUS 447  
4900 AK OOSTERHOUT  
Netherlands

Verzendadres certificaten/Cert receiver

Afleveradres/Delivery address  
Lasaulec Heerenveen  
Kuper 4  
HEERENVEEN  
8447 GK HEERENVEEN  
Netherlands

LEVERING/DELIVERY

Lotnummer/Lot no:

PVX1810184

Hoeveelheid/Quantity: 1 RL

## PRODUCT/PRODUCT

Merk/Brand: ESAB  
Omschrijving/Desc: OK Autrod 12.64 1.2mm 18kg  
Artikelnummer/Item no: 1264127710  
Heat No/Heat number: 25661  
Hoeveelheid/Quantity: 1 RL

## CHEMISCHE SAMENSTELLING/CHEMICAL ANALYSIS

Actual results: acc to EN 10204 - 3.1

### Wire/strip

|       |         |
|-------|---------|
| C     | 0.07%   |
| Si    | 0.90%   |
| Mn    | 1.65%   |
| P     | 0.015%  |
| S     | 0.014%  |
| Cr    | 0.04%   |
| Ni    | 0.02%   |
| Mo    | 0.01%   |
| Cu    | 0.08%   |
| V     | < 0.01% |
| Al    | < 0.01% |
| Ti+Zr | 0.01%   |

## CLASSIFICATIES/CLASSIFICATIONS

EN ISO 636-A: W 46 3 4Si1  
EN ISO 636-A: W4Si1  
EN ISO 14341-A: G 4Si1  
EN ISO 14341-A: G 42 3 C1 4Si1  
EN ISO 14341-A: G 46 5 M21 4Si1  
SFA/AWS A5.18: ER70S-6

## MECHANISCHE EIGENSCHAPPEN/MECHANICAL PROPS

Typical data: acc to EN 10204 - 2.2

### Tensile

| Standard | Shielding Gas | ReL [MPa/ksi] | Rm [MPa/ksi] | A5 [%] |
|----------|---------------|---------------|--------------|--------|
| EN       | M21           | 490/71        | 590/86       | 29     |

### Impact

| Standard | Shielding Gas | Temp [°C/°F] | KV[J/ft-lb] |
|----------|---------------|--------------|-------------|
| EN       | M21           | +20/68       | 130/96      |
| EN       | M21           | -20/-4       | 120/89      |
| EN       | M21           | -30/-22      | 100/74      |
| EN       | M21           | -40/-40      | 90/66       |
| EN       | M21           | -50/-58      | 80/59       |

A4, A5 = Elongation  
ReH = Upper Yield Point  
ReL = Lower Yield Point  
Rm = Ultimate Tensile Strength (UTS)  
Rp0.2 = Yield Strength 0.2 offset  
Rp1.0 = Yield Strength 1.0 offset

## OPMERKINGEN/COMMENTS

Product geleverd volgens een QA systeem welke voldoet aan de ISO 9001 norm.

Dit certificaat is elektronisch aangemaakt.

Voor vragen:

Esab Nederland BV - P.O. Box 2236, 3800 CE Amersfoort, Nederland

Product supplied under a QA Programme fulfilling the EN ISO 9001 standard.

This certificate is produced electronically.

Please refer any queries to: (see above)

## Geldigheid/Validation

Josef Moravek

Quality Manager

Helene Rasmuson

Product Manager