

Test Certificate: 105189

To:
PARWELD LIMITED
BEWDLEY BUSINESS PARK
LONG BANK
BEWDLEY
WORCS
DY12 2TZ

Date: 03/10/2019

Order No: 22121

Advice Note No: 54035

Material:
A32
1.0mm
TIG x 5KG

Quantity, KG:
5

Cast No:	492030
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Specification:

AWS A5.28/A5.28M: ER80S-G
BS EN ISO 21952-A: W CrMo1Si

Chemical Analysis EN 10204: 3.1

C	Si	Mn	P	S	Cr	Ni	Mo	Fe	Cu *
0.08	0.57	0.98	0.006	0.011	1.18	0.04	0.50	Bal	0.037
W	Nb	Al	V	Ti	Co	Pb	Sn	B	As
	0.002	0.002	0.006	0.002	0.0010	0.001	0.004	0.0010	0.001
Zr	Ta	Sb	N	Bi	Zn	Mg	Be	Ce	Ca
0.001	0.001	0.0010							
Ag	Ga	Y				X Factor	FN-WRC	OE **	TOE **
									<0.50

* Copper excluding copper coating. ** Other elements individual. *** Other elements total.

Mechanical properties of pure weld metal EN ISO 15792-1 test report EN 10204: 2.2

TYPE	PWHT °C/hr	Rp0.2 %		Rm		A5		Av	
		Min	Result	Min	Result	Min	Result	Min	Result
TIG	PWHT	MPa	MPa	MPa	MPa	%	%	J @ °C	J @ °C
		≥ 355	442	≥ 510	545	≥ 20	28	≥ 47 @ -10	177 @ -10

Certified that the product(s) detailed hereon have been inspected and tested in accordance with the conditions and requirements of the purchase order and unless otherwise noted conform in all respects to the specifications relevant thereto.

Signed:

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