



Certificate of Conformance to Requirements for Welding Electrode

Product Type: HOBALLOY 8018B2
Classification: E8018-B2 H4R
Specifications: AWS A5.5/A5.5M; ASME SFA 5.5
Diameter Tested:
Date Tested: 11/25/2020
Date Generated: 3/3/2022

This is to certify that the product named above and supplied on the referenced order number is of the same classification, manufacturing process, and material requirements as the material which was used for the test that was concluded on the date shown, the results of which are shown below. All tests required by the specifications shown for classification were performed at that time and the material tested met all requirements. It was manufactured and supplied by the Quality System Program of Hobart Brothers, which meets the requirements of ISO 9001, ANSI/AWS A5.01, and other specification and Military requirements, as applicable. This document supplies actual test results of non-specific inspection in conformance with the requirements of EN 10204, type 2.2 certification.

MADE IN THE U.S. OF U.S. AND IMPORTED MATERIALS.

Test Settings

Size	Polarity	Amps	Volts	Preheat F(C)	Interpass F(C)
5/32X14 in	AC	200	24	325 (163)	375 (191)
3/16X14 in	DCEP	225	25	325 (163)	375 (191)
3/16X14 in	AC	235	25	325 (163)	375 (191)
5/32X14 in	DCEP	170	26 - 24	325 (163)	375 (191)

Mechanical Properties - Tensile

Size / Polarity	Ref. No.	Testing Conditions	Ult. Tensile Strength psi(MPa)	Yield Strength psi(MPa)	Elong.% in 2"
3/16X14 in / DCEP	PE3392	SR 1 Hr @ 1275F	96,000 (658)	82,000 (562)	22
3/16X14 in / AC	PE3394	SR 1 Hr @ 1275F	99,000 (683)	86,000 (596)	22
5/32X14 in / DCEP	PE3427	SR 1 Hr @ 1275F	108,000 (745)	95,000 (655)	22
5/32X14 in / AC	PE1593	SR 1 Hr @ 1275F	98,000 (672)	84,000 (581)	24

Size / Polarity	Ref. No.	Radiograph	Fillet Weld Test			
3/16X14 in / DCEP	PE3392	Conforms	Horizontal :	Conforms	Overhead :	Vertical :
3/16X14 in / AC	PE3394	Conforms	Horizontal :	Conforms	Overhead :	Vertical :
5/32X14 in / DCEP	PE3427	Conforms	Horizontal :		Overhead :	Vertical : Conforms
5/32X14 in / AC	PE1593	Conforms	Horizontal :		Overhead :	Vertical : Conforms

Chemical Analysis

Size / Polarity / Ref. No.	C	Mn	P	S	Si	Cu	Cr	V	Ni	Mo	Al	Ti	Nb	Co	B	W	Sn	Fe	Sb	N	Mg	Zn	Be	Sb	As
3/16X14 in / DCEP / PE3392	0.09	0.69	0.01	0.01	0.62		1.33			0.50															
3/16X14 in / AC / PE3394	0.09	0.69	0.01	0.01	0.64		1.29			0.50															
5/32X14 in / DCEP / PE3427	0.07	0.73	0.01	0.01	0.69		1.39			0.52															
5/32X14 in / AC / PE3430	0.08	0.68	0.01	0.01	0.60		1.29			0.49															

3/16X14 in / PE3392	Total H2O Method : Train - As Received	Total Coating Moisture : 0.065
3/16X14 in / PE3394	Total H2O Method : Train - 9 Hour	Total Coating Moisture : 0.248
5/32X14 in / PE3427	Total H2O Method : Train - As Received	Total Coating Moisture : 0.04
5/32X14 in / PE3430	Total H2O Method : Train - 9 Hour	Total Coating Moisture : 0.193

Diffusible Hydrogen Collected per AWS A4.3

2.8 ml/100g of weld metal for 3/16X14 in diameter 19% relative humidity
2.4 ml/100g of weld metal for 5/32X14 in diameter 19% relative humidity

Dave Thomas, Quality Assurance Rep.

Certification and Limited Warranty - Data for the above supplied product are those obtained when welded and tested in accordance with the above specification. All tests for the above classification were satisfied. Other tests and procedures may produce different results.