Product: Fabshield XLNT-6
Diameter: 3/32”
Shielding Gas: N/A
Current/Polarity: DCEP
Classification: AWS E70T-6
Specification: AWS A5.20/A5.20M:2021
Test Completed: 6/21/2022

Certificate of Conformance
For AWS D1.8/D1.8M, Seismic Supplement

This is to certify that the product named herein is of the same classification, manufacturing process, and material requirements as the material used for the tests completed on the date shown, the results of which are recorded below. All tests 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 Management System 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- # F05735	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	69.8 kJ/in	40.0 kJ/in	Mechanical Properties		69.8 kJ/in	40.0 kJ/in
Voltage	25	21.8	Test Reference #		PE4114	PE4265
Current (amps)	475	335				
WFS (ipm)	300	135				
Travel Speed (ipm)	10.2	10.7	Tensile Strength (psi)	70,000	76,000	91,000
Stick Out	1.25”	1”	Yield Strength (psi)	58,000	59,000	75,000
# of passes	7	13	Elongation (%)	22	27	22
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	46	40
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # C001421501313	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	73.5 kJ/in	42.8 kJ/in	Mechanical Properties		73.5 kJ/in	42.8 kJ/in
Voltage	26	25	Test Reference #		PD7586	PD7473
Current (amps)	445	310				
WFS (ipm)	260	125				
Travel Speed (ipm)	9.4	10.87	Tensile Strength (psi)	70,000	77,000	93,000
Stick Out	1”	1”	Yield Strength (psi)	58,000	58,000	77,000
# of passes	6	13	Elongation (%)	22	28	22
# of layers	4	6	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	51	42
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
Weld Position	1G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # Z006572402502	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	70.8 kJ/in	41.3 kJ/in	Mechanical Properties		70.8 kJ/in	41.3 kJ/in
Voltage	26	22	Test Reference #		PD0962	PD1068
Current (amps)	443	322				
WFS (ipm)	260	140				
Travel Speed (ipm)	9.75	11.68	Tensile Strength (psi)	70,000	80,000	94,000
Stick Out	1”	1”	Yield Strength (psi)	58,000	59,000	75,000
# of passes	7	12	Elongation (%)	22	24	24
# of layers	4	5	Average Charpy V-notch			
Preheat Temp. ºF	300+/-25	RT	Impact Properties ft•lbs @	40	47	45
Interpass Temp. ºF	500+/-50	200+/-25	+70 ºF			
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	F05735	HB5550	7.1 (ml/100g)
7 Day Exposure	F05735	HB5585	7.8 (ml/100g)

David A. Thomas, Quality Assurance Specialist