



**BUY AMERICA**  
CONSUMABLES

**LINCOLN**<sup>®</sup>  
**ELECTRIC**



## What is Buy America?

The American Recovery and Reinvestment Act (ARRA) is an economic stimulus act to create and save jobs in the U.S while rebuilding the infrastructure. A provision of this Act is Buy America which requires all steel components of welding consumables to be made and melted in the United States. These requirements are becoming more prevalent in the structural and bridge fabrication and erection industries.

Lincoln Electric offers a wide variety of quality welding consumables that meet the Buy America requirements. For more information on Buy America visit our website. [www.lincolnelectric.com/buyamerica](http://www.lincolnelectric.com/buyamerica)



## Pride in the U.S.A

For over 115 years, we have taken pride in providing our customers with high quality consumables. We offer a variety of Buy America consumable products for many processes: SMAW, GMAW, FCW, SAW. These products are easy to identify on the Lincoln Electric website with the (BUY AMERICA) suffix in the product name. Lincoln Electric is dedicated to supporting the Buy America program by continually adding products to this portfolio.

**CERTIFICATE CENTER**

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Global Agency Certifications   FEMA Certificates   AWS D1.8 Certificates   AWS D1.1 Certificates

**Certificates of Conformance** - (These certificates of conformance do not reference a Q1 Lot number)

Select a Product Name  **Select**

OR

Search by  **Search**

Name / Cert # / Classification

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**Q1 Certificate of Conformance** - (Applicable certificate of conformance for a specific Q1 Lot)

Input Q1 Lot Number  **GENERATE PDF** Example: Q1 Lot 12135190, enter 12135190 into the field

**Q1 Certificate of Actual Chemistry** - (For Q1 Schedule K Flux and Schedule H Subarc Wire certificates only)

Input Q1 Lot Number  **GENERATE PDF** Example: Q1 Lot 11905153, enter 11905153 into the field

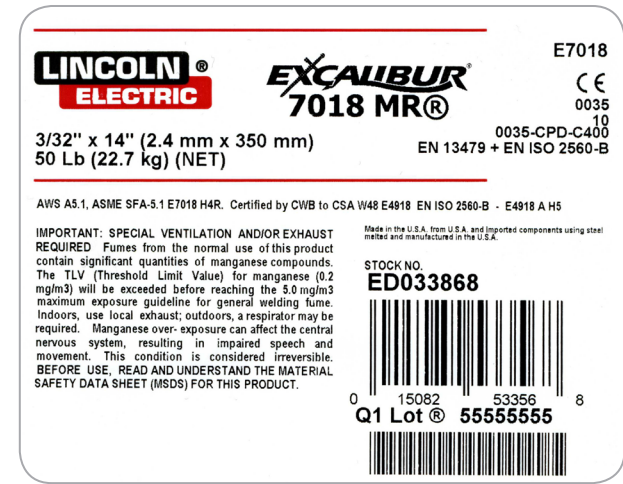
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## Product Labels

All Buy America products contain information on the product label to confirm the origin of the steel being used.

## Certificates

Certificates of Conformance are available for Buy America products through the Certificate Center on the Lincoln Electric website. Q1 certificates for Buy America products state that the material was produced with steel melted and manufactured in the U.S.

To access UltraCore®, Excalibur®, Pipeliner®, and SuperArc® product certificates, visit the Certificate Center and enter the product's Q1 Lot® number into the field under the Q1 Certificate of Conformance.

For Lincolnweld® products, enter the product's Q1 Lot® number into the Q1 Certificate of Actual Chemistry.

Certificate Center: [www.lincolnelectric.com/certificate-center](http://www.lincolnelectric.com/certificate-center)

Operating Settings		RESULTS			
Electrode Size	5/32 inch	5/32 inch	3/16 inch	3/16 inch	
Polarity	AC	DC+	AC	DC+	
Plate Thickness, mm (in)	19 (3/4)	19 (3/4)	19 (3/4)	19 (3/4)	
Current, A	185	170	240	210	
Pass/Layers	14/7	14/7	14/7	14/7	
Preheat Temperature, °C (°F)	(225 min.)	120 (250)	120 (250)	120 (250)	
Interpass Temperature, °C (°F)	(225 - 350)	165 (325)	165 (325)	165 (325)	
Postweld Heat Treatment	As-welded	As-welded	As-welded	As-welded	
Mechanical properties of weld deposits					
Tensile Strength, MPa (ksi)	(70 min.)	540 (78)	530 (77)	560 (80)	550 (80)
Yield Strength, 0.2% Offset, MPa (ksi)	(58 min.)	440 (64)	430 (62)	470 (68)	460 (67)
Elongation	22 min.	31	31	29	31
Average Impact Energy	(20 min.)	168 (124)	372 (274)	156 (115)	152 (112)
Joules @ -29 °C (ft-lbs @ -20 °F)		164,167,172 (121,123,127)	347,382,386 (256,282,285)	145,152,171 (107,112,126)	136,149,171 (100,110,126)
Average Hardness, HRB	Not Required	86	85	88	88



## What is Buy America Made-To-Stock?

Buy America Made-to-Stock (MTS) products are off-the-shelf materials structured specifically to meet the requirements of Buy America.

Buy America MTS Products feature:

- Steel melted and manufactured in the U.S.
- Product in stock for immediate delivery.
- Online access to Q1 certificates of conformance with statement of origin for green rod.
- No minimum order quantity.
- All Buy America consumables feature the same industry-leading performance as their standard counterparts. Additionally, these products are manufactured using green rod melted and manufactured in U.S. steel mills.
- Unique part numbers differentiate these products from standard product.
- For a complete list of Buy America consumables, visit our website. [www.lincolnelectric.com/buyamerica](http://www.lincolnelectric.com/buyamerica)

#### CUSTOMER ASSISTANCE POLICY

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com](http://www.lincolnelectric.com) for any updated information.



Publication MC14-81 | Issue Date 06/14  
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