

CERTIFICATE OF CONFORMANCE



Lincoln Electric Company of Canada LP
 939 Gana Court
 Mississauga, Ontario
 Canada L5S 1N9

Product: SuperGlaze® 1100
 Classification: ER 1100
 Specification: AWS A5.10/A5.10M: 2023, ASME SFA-5.10
 Date Completed: 1/25/2024

This is to certify that the product named above is of the same classification(s) and design as the material used for the tests reported herein. The material was tested according to the specification(s) indicated and met all requirements. It was manufactured and supplied according to a Quality System Program that meets the requirements of ISO 9001.

Welding Parameters for Groove Weld Mechanical Testing

Operating Settings:	Requirement	Results
Wire size (Inch)	1/16	1/16
Wire Feed Speed (IPM)	150-350	250-300
Shielding Gas	100%Ar	100%Ar
Travel Speed (IPM)	20-35	25
Arc Voltage (V)	23-29	26.5-28
Resulting Current DCEP (A)	200-350	225-275
CTWD (Inch)	¾-1	¾

Mechanical Properties of Weld Metal

Parameters	Requirement	Results
Yield Strength (KSI)	Not Specified	11
Tensile Strength (KSI) Min	11	15
Elongation (%)	Not Specified	29

Chemical Composition of Electrode

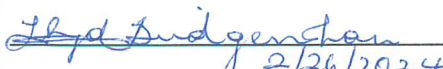
Chemical Composition of Electrode AWS A5.10/A5.10M: 2023, ASME SFA-5.10		Results (% by Wt.)
Element	Requirements (% by Wt.)	
Si+Fe	0.95 Max.	0.17
Cu	0.05-0.20	0.09
Mn	0.05 Max	0.002
Cr	-	0.001
Zn	0.10 Max.	0.004
Ti	-	0.009
Mg	-	0.002
Be	0.0003 Max.	0.0000
Al	99.00 Min.	99.719


Soundness and Usability Test

Soundness and Usability test results met requirement.

Note

- This certificate meets the requirements of EN 10204, type 2.2, when specific lot or order number is referenced.
- The size(s) of electrode tested is determined by the requirements for classification. All other sizes manufactured will also meet these requirements.


 Approved By: QA Manager / Date 2/26/2024


 Approved By: Metallurgist / Date 02/26/24


 Approved By: Manager Technical Services / Date

Cert No. 24-008