

CERTIFICATE OF CONFORMANCE



Product: **RADNOR® 7014**
 Classification: **E7014**
 Specification: **AWS A5.1:2012, ASME SFA-5.1**
 Date: **March 27, 2020**

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 the specification(s) indicated and met all requirements. It was manufactured and supplied according to a Quality System Program that meets the requirements of ISO9001 among others as documented on The Lincoln Electric web page (<http://www.lincolnelectric.com/en-us/company/Pages/certifications.aspx>).

Operating Settings	E6011 Requirements	RESULTS	
Required Size for Classification		5/32" (4.0 mm)	5/32" (4.0 mm)
Current Type / Polarity	AC, DC+	AC	DC+
Nominal Voltage, V		24	26
Nominal Current, A		150	150
Average Heat Input, kJ/mm (kJ/in)		1.6 (40)	1.3 (32)
Travel Speed, cm/min (in/min)		14.9 (5.9)	14.7 (5.8)
Pass/Layers		16/8	18/9
Preheat Temperature, °C (°F)	105 (225 min.)	150 (300)	150 (300)
Interpass Temperature, °C (°F)	105-175 (225-350)	150 (300)	150 (300)
Postweld Heat Treatment	As-welded	As-welded	As-welded

Mechanical Properties of Weld Metal

Tensile Strength, MPa (ksi)	490 (70) min.	515 (75)	500 (73)
Yield Strength, 0.2% Offset, MPa (ksi)	400 (58) min.	440 (64)	410 (60)
Elongation %	17 min.	21	25

Chemical Composition of Weld Metal (weight %)

C	0.15 max.	0.11	0.05
Mn	1.25 max.	0.18	0.41
Si	0.90 max.	0.18	0.19
P	0.035 max.	0.010	0.021
S	0.035 max.	0.012	0.013
Ni	0.30 max.	0.02	0.02
Cr	0.20 max.	0.02	0.02
Mo	0.30 max.	0.00	0.00
V	0.08 max.	0.01	0.01
Mn + Ni + Cr + Mo + V	1.50 max.	0.23	0.46

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1. This document meets the requirements of EN10204, type 2.2, when a specific lot or order number is referenced. It does not meet the requirements of type 3.1.
2. The electrode sizes required to be tested for this classification are 5/32 inch. All other sizes manufactured will also meet these requirements.
3. Fillet Weld Test (positions as required): Met requirements.
4. Radiographic Inspection: Grade 2 - Met requirements.
5. The strength and elongation properties reported here were obtained from tensile specimens artificially aged at 105°C (220°F) for 48 hours.
6. Strength values in SI units are reported to the nearest 10 MPa converted from actual data. Preheat and interpass temperature values in SI units are reported to the nearest 5 degrees.

Javier Hernandez Gonzalez
Quality Assurance

March 27, 2020
Date

Roque Sanchez de Lucio
Quality Assurance Manager

03/27/2020
Date