

**Lincoln Electric Europe BV – Buzau Plant**  
 Aleea Industriilor, Nr. 1-1 BIS,  
 120068 Buzau - Romania

**CERTIFIED MATERIAL TEST REPORT**

Product: UltraCore® 360™ C71 diameter 1/16" - 1.6 mm  
 Lot Nr. : M1FC194128  
 Classification: ASME SFA-5.20: E71T-1C-JH4  
 ASME SFA-5.36: E71T1-C1A2-CS1-H4  
 Test Completed: December 17, 2021

This is to certify that the above listed product was manufactured to meet the Class T3 requirements of AWS A5.01 as required by clause 6.3.8 of AWS D1.8/D1.8M: 2009.

Test Conditions	AWS D1.8 requirements	High Heat Input Results	Low Heat Input Results
Electrode Size		1/16" - 1.6 mm	1/16" - 1.6 mm
Electrode Polarity		DC+	DC+
Wire Feed Speed m/min (inc/min)		3.5 (138)	5.8 (217)
Welding speed cm /min (inc/min)		8.6 (3.4)	39.1 (15.4)
Current (amps)		200	290
Arc Voltage (volts)		23	28
CTWD mm/(inch)		18 (0.71)	18 (0.71)
Preheat	Low ≤ 40°C High ≥ 120°C	150 (302)	23 (73)
Interpass Temp °C (°F)	Low ≤ 120°C High ≥ 240°C	260 (500)	120 - (248)
Heat Input Avg. kJ/mm (kJ/in.)	Low ≤ 1.2, High ≥ 3.1	3.2 (81)	1.2 (30.5)
Shielding Gas Used	C1	CO2	CO2
Weld position		3G (vertical up)	1G

Mechanical Properties	Actual Results of AWS D1.8 requirements	High Heat Input Results	Low Heat Input Results
Yield Strength, MPa (ksi) (0.2% offset method)	400 (58 min.)	449 (65)	538 (78)
Tensile Strength MPa (ksi)	480 (70 min)	528 (77)	589 (85)
Elongation %	22% min	35%	29%

Impact Properties	AWS D1.8 requirements	High Heat Input Results	Low Heat Input Results
Temperature	10 °C (20 °F)	Tested @ 10°C (20° F)	Tested @ 10°C (20° F)
Average Joules (ft-lbs)	54 min (40 min)	189 (139)	184 (136)
Individual Values Joules		189; 186; 192	183; 185; 185

This is to certify that the contents of this report are correct and accurate as contained in the records of The Lincoln Electric Company.



Name, C. Dascaiu  
 QC Manager Buzau Plant

12/01/2022  
 Date