

CERTIFICATE OF CONFORMANCE



Electrode: **UltraCore® XP70**
 Electrode Size **3/32" (2.4 mm)**
 Specification: **AWS D1.8:2021**
 Date: **February 28, 2025**

This is to certify that the above listed product was manufactured to meet the Class T4 requirement of AWS A5.01 as required by clause 6.3.1.2 of AWS D1.8:2021.

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>).

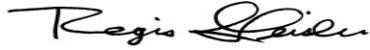
| Operating Settings | High Heat Input Requirements | Low Heat Input Requirements | High Heat Input Results | Low Heat Input Results |
|---------------------------------------|------------------------------|-----------------------------|-------------------------|------------------------|
| Electrode Lot | | | 18926753 | 18926753 |
| Base Material | | | ASTM A36 steel | ASTM A36 steel |
| Current Type/Polarity | | | DC+ | DC+ |
| Plate Thickness, mm (in) | (3/4) | (3/4) | 19 (3/4) | 19 (3/4) |
| Wire Feed Speed, cm/min (in/min) | | | 508 (200) | 508 (200) |
| Nominal Voltage, V | | | 29.0 | 29.0 |
| Nominal Current, A | | | 490 | 490 |
| Average Heat Input, kJ/mm (kJ/in) | Not Specified | Not Specified | 3.2 (80.9) | 1.5 (38.8) |
| Travel Speed, cm/min (in/min) | | | 27 (10.6) | 56 (22.0) |
| Contact Tip to Work Distance, mm (in) | | | 25 (1.00) | 25 (1.00) |
| Pass/Layers | | | 8/5 | 17/6 |
| Preheat Temperature, °C (°F) | (250 min.) | (120 max.) | 150 (300) | 20 (72) |
| Interpass Temperature, °C (°F) | (450 min.) | (250 max.) | 245 (475) | 95 (200) |
| Postweld Heat Treatment | As-welded | As-welded | As-welded | As-welded |
| Weld Position | | | 1G | 1G |
| Shielding Gas | Not Specified | Not Specified | 100% CO2 | 100% CO2 |

Mechanical properties of weld deposits

| | | | | |
|--|-----------|-----------|--------------------------------|--------------------------------|
| Tensile Strength, MPa (ksi) | (70 min.) | (70 min.) | 550 (80) | 610 (89) |
| Yield Strength, 0.2% Offset, MPa (ksi) | (58 min.) | (58 min.) | 450 (66) | 550 (80) |
| Elongation % | 22 min. | 22 min. | 29 | 24 |
| Average Impact Energy Joules @ 21 °C (ft-lbs @ 70 °F) | (40 min.) | (40 min.) | 63 (47) 58,64,68 (42,47,50) | 72 (53) 68,73,77 (50,54,57) |

1. This product satisfies the requirements of AWS D1.8:2021, Annex E, after exposure for 1 week at 80°F / 80% relative humidity.
2. The Charpy V-notch impact values reported at 21 °C (70 °F) are required when the Lowest Anticipated Service Temperature (LAST) is 10 °C (50 °F).
3. Lot testing exemption as defined in AWS D1.8/D1.8M: 6.3.3 by testing a minimum of 3 lots for approval has been completed. For further questions please contact customer service. <https://www.lincolnelectric.com/en/Ask-the-Experts/Contact-Us>
4. The strength and elongation properties reported here were obtained from tensile specimens artificially aged at 105°C (220°F) for 48 hours.
5. 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.


 February 28, 2025
 Daniel Gaul, Certification Supervisor Date


 February 28, 2025
 Regis Geisler, Manager, Consumable Compliance Date