



Product: FabCO XL-525
Diameter: .052"
Shielding Gas: M21-ArC-25
Current/Polarity: DCEP
Classification: E71T-1M; E71T-12MJ H8
Specification: AWS A5.20/A5.20M:2005
Test Completed: 2/13/2023

Certificate of Conformance

For AWS D1.8/D1.8M, Seismic Supplement

This is to certify that the product named is of the same classification, manufacturing process, and material requirements as the material, which was used for the test which was concluded on the date shown, the results of which are shown below. All test required by the code or specifications were performed at that time and the material tested met all requirements. The product was manufactured and supplied by the Quality System Program of Hobart Brothers, which meets the requirements of ISO9001:2015, ANSI/AWS A5.01, and other specification and Military requirements, as applicable.

Test Settings	High Heat Input	Low Heat Input	Lot- # D000032205711	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	83.9 kJ/in	29.1 kJ/in	Mechanical Properties		80.5 kJ/in	29.1 kJ/in
			Test Reference #		PD9135	PD9151
Voltage	25	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	74,000 66,000 30 166	81,000 75,000 26 127
Current (amps)	220	250				
WFS (ipm)	230	290				
Travel Speed (ipm)	4.1	13.9				
Stick Out	3/4"	3/4"				
# of passes	8	20				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # A003812308003	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	83.9 kJ/in	27.0 kJ/in	Mechanical Properties		83.9 kJ/in	27.0 kJ/in
			Test Reference #		PD3279	PD3278
Voltage	26	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	76,000 65,000 30 183	83,000 77,000 25 127
Current (amps)	250	250				
WFS (ipm)	325	290				
Travel Speed (ipm)	4.2	15				
Stick Out	3/4"	3/4"				
# of passes	7	20				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Test Settings	High Heat Input	Low Heat Input	Lot- # H60083	AWS D1.8 Requirements	High Heat Input	Low Heat Input
	83.7 kJ/in	29.3 kJ/in	Mechanical Properties		83.7 kJ/in	29.3 kJ/in
			Test Reference #		PE5660	PE5443
Voltage	25	27	Tensile Strength (psi) Yield Strength (psi) Elongation (%) Average Charpy V-notch Impact Properties ft•lbs @ +70 °F	70,000 58,000 22 40	77,000 69,000 29 128	83,000 78,000 26 144
Current (amps)	220	250				
WFS (ipm)	230	290				
Travel Speed (ipm)	3.9	14.4				
Stick Out	3/4"	3/4"				
# of passes	8	18				
# of layers	4	7				
Preheat Temp. °F	300+/-25	RT				
Interpass Temp. °F	500+/-50	200+/-25				
Weld Position	3G	1G				

Diffusible Hydrogen - Tested in accordance with AWS A5.20/A5.20M, Clause 16 & Extended Exposure - in accordance with AWS D1.8/D1.8M

Condition	Lot - #	Test Reference #	Average (ml/100g)
As Received	H60083	HB6486	3.7 (ml/100g)
7 Day Exposure	H60083	HB6508	7.5 (ml/100g)

The information contained or otherwise referenced herein is presented without guarantee or warranty. Hobart Brothers LLC ("Hobart") expressly disclaims any liability incurred from any reliance thereon. Data for the above-supplied product are those obtained during the welding process and tested in accordance with the above specification with electrodes of the same manufacturing processes and material requirements. All tests for the above classification were performed satisfactorily. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart. Please refer to the Hobart Brothers Company website at www.hobartbrothers.com for current Safety Data Sheets ("SDS").

James Owens, Quality Assurance Specialist