

CERTIFICATE OF QUALITY

TOKO E501T8-K6

CATEGORY: SELF-SHIELDED FLUX CORED WIRE FOR LOW TEMPERATURE STEEL

APPLICATIONS: Vertical down hot, fill and cap pass welding of up to X70 grade pipe
Capable of producing weld deposits with impact toughness exceeding 27 J at -29°C (-20°F).

CLASSIFICATION: AWS A5.29/A5.29: 2005 E71T8-K6 | GB/T17493-1998 E501T8-K6

WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT % :

	Chemical Composition (%)						
	C	Si	Mn	P	S	Al	Ni
Requirements	<0.15	<0.8	0.5~1.5	<0.03	<0.03	<1.8	0.4~1.1
Typical result	0.3~0.5	0.90	0.9~1.1	25~27	0.014	34~36	1.2~1.5
2.8MM	Melting metal mechanical performance						
	Tensile Strength R(MPa)	Yield R(MPa)	Elongation A(%)	Akv(J) -30°C			
Requirements	>490	>400	>20	>27			
Typical result	540	452	27	167			

Quality Control Stamp:

Date: March-17,2019

