



RASI ELECTRODES LIMITED

Chennai – 52.

ISO – 9001:2015 CERTIFIED



BATCH TEST CERTIFICATE

Consumable: GMAW

| Product Name | Dimension in mm | Batch No | Month Of Mfg. | B.T.C No | Applicable | |
|--------------|-----------------|----------|-----------------|----------|----------------|----------------|
| | | | | | Specification | Classification |
| RASI CO2 | Ø1.20 | 033 | NOVEMBER - 2024 | 033 | ASME SFA/A5.18 | AWS:ER70S-6 |
| | | | | | IS 6419 : 1996 | S4-C-504 |

| Chemical analysis of the wire % | | | | Mechanical Properties of the weld metal | | Special Properties | |
|--|--------------|----------|--------------|---|--------------|---|--------------|
| Elements | Test Results | Elements | Test Results | Type of Test | Test Results | Type of Test | Test Results |
| C | 0.07 | Cr | 0.017 | Yield Strength N/mm ² | 483 | Hydrogen in Weld metal ml/100gms | 3.20 |
| Mn | 1.45 | Ni | 0.012 | Ultimate Tensile Strength N/mm ² | 587 | Radiography | Satisfactory |
| Si | 0.85 | Mo | 0.004 | Elongation% Gauge Length=4d | 30.2 | Fillet weld Test | Satisfactory |
| S | 0.016 | V | 0.002 | CVN Impact Test @-30°C Joules | 112.6 | We certify that the supply made against this BTC conforms to all requirements of IS 6419 : 1996 ASME Section II Part C - 2023 in all respects | |
| P | 0.018 | Cu | 0.208 | Filler Metal Wire Strength | 1294 | | |
| NR Means "Not Required" Factory : Upparalayam Village, Almathi Post, Redhills, Chennai-600052. Customer care : +91-044-26401822. | | | | | | | |



RE/INS/F11/Rev07