I.N.E. INDUSTRIA NAZIONALE ELETTRODI s.p.a.

CAPITALE SOCIALE € 1.248.000 I.V. - 35013 CITTADELLA (PADOVA) ITALIA - VIA FACCA, 10
TELEFONI ++39 049 94.81.111 R.A. - FAX ++39 049 9400249 - CCP 15385354 - CODICE FISCALE e PARTITA IVA IT00202750287
REA PD N. 56139 - Reg. Imp. PD 00202750287 - Internet: www.ine.it - E-mail: ine@ine.it

Member of CISQ Federation
RINA
ISO 9001:2008
Sistema Qualità Certificato

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Inspection Certificate          98376


Type      INETIG D2          Client    301192      MIGATRONIC AS
                                                    SVEJSEMASKINEFABRIKKEN
          MIGA TIG KV2                              AGGERSUNDVEJ 33
                                                    9690  FJERRITSLEV    DANIMARCA


INE Order No.   22179    Dated 11/01/2013
Customer Ref. PO 8039419 DD 11.01.13
Norms
AWS A 5.28: ER80S-D2              EN ISO 14341-A: G 50 5 M21 4 Mo
Reference:
  C    Si    Mn    S     P     Cu    Ni    Cr    Mo    Al    V     Zr+Ti  O     N
 ,070  ,500 1,700  ,000  ,000  ,000  ,000  ,000  ,400  ,000  ,000  ,000   ,000  ,000
 ,120  ,800 2,100  ,025  ,025  ,350  ,150  ,150  ,600  ,020  ,030  ,150   ,010  ,010


SECTION 1
CHEMICAL COMPOSITION WIRE:

Heat Number    : 4/2664   – 115573
Diam. : mm      1,60
  C    Si    Mn    S     P     Cu    Ni    Cr    Mo    Al    V     Zr+Ti  N
 ,071  ,700 1,810  ,011  ,013  ,170  ,060  ,100  ,450  ,004  ,004  ,003   ,008        .

                                                                              .


SECTION 2
MECHANICAL PROPERTIES WELD METAL                                    RESULT
Tensile strength            Rm           620-   720 MPa          640
Yield strength              Rs               >= 540 MPa          550
Elongation                  A5d              >=  18,0 %          21,0
Charpy V-Notch at  50- C°   Kv               >=   47 Joule       60
Hardness                    HRc              >=       HRc


We certify that this product is made in Italy by INE Spa and is in accordance with the above norms.
Radiographic test by Xray: Satisfactory.


Cittadella,  25/01/2013                              Signature
                                                  I.N.E.  S.p.A.
                                          Industria Nazionale Elettrodi
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