



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



CAPITALE SOCIALE € 1.248.000 I.V. - 39013 CITTADILLA (PD) ITALIA - VIA FACCA, 10  
 TELEFONI ++39 049 94 81 111 R.A. - FAX ++39 049 9400219 - CCP 15385354 - CODICE FISCALE e PARTITA IVA 1100202750287  
 RFA PD N. 58139 - Rag. Imp. PD 00202750287 - Internet: www.ine.it - Email: ine@ine.it

Inspection Certificate 125131

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

INE Order No. 41404 Dated 18/12/2014

Customer Ref. 8056493 DD 17.12.14

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 : 4/2935

Batch/Lot Number : 150223

Diam. : mm 1,60

C	Si	Mn	S	P	Cu	Ni	Cr	Mo	Al	V	Zr+Ti	N	Ti
,090	,700	1,830	,006	,013	,160	,090	,087	,460	,006	,005	,004	,009	,002
Zr	Nb	Sb	Sn	As	Co								
,002	,003	,002	,005	,002	,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, 2/03/2015

Signature  
 I.N.E. S.p.A.  
 Industria Nazionale Elettrodi

Conforms To ASME II, Part C, SFA 5.01, Schedule F, Class S3

Document according to UNI EN 10204/2005 - SECTION 1:par.3.1

SECTION 2:par.2.2

During the manufacturing processes, examinations and tests, the material did not come in direct contact with mercury or any of its compounds, nor with any mercury containing device employing a single boundary of containment.

The radioactivity of the heat is less than 100 Becquerels per kilogram.

Material manufactured in accordance with Quality Assurance Manual Reference : INE Edition 03 dd 22 May 2013

This certificate is electronically generated and valid without signature.