



# Welding Consumable : Statement of Fact

Project: **Supplementary list of Welding consumables**

Client: **Ador Welding Limited, Silvasa plant, India**

Office: **Mumbai**

Client's Order Number: **--**

Date: **26 June 2023**

Order Status: **Complete**

Inspection Dates

First: **04 April 2023**

Final: **02 June 2023**

This statement is issued to **Ador Welding Limited, Silvasa plant, India** to certify that the undernoted welding consumable is recommended for entry in the supplementary list of certified welding consumables in accordance with ASME Section II Part C, SFA 5.18, ER70S-2 specification of the year 2019. This statement is issued on the basis of satisfactory test results on the test coupons prepared on 04/04/2023 and subsequently tested on 02/06/2023.

Welding consumables is manufactured by Ador Welding Limited, Silvasa plant, India.

## Description:-

Consumable Name : TIGFIL 70S-2

Size : 2.4 and 3.15mm

SFA Classification : SFA / AWS 5.18 ER70S-2

## Result of the Test :

Size	2.4 X 1000mm	3.15 X 1000mm
0.2%Proof Stress (MPa) (Min.: 400MPa)	543	527
UTS (MPa) (Min.: 490MPa)	619	617
% Elongation (Min. 22%)	26	27
Hydrogen test	Not Required	Not Required
Chemical	Acceptable	Acceptable
Radiography	Acceptable	Acceptable
Fillet (H,V,OH)	Not Required	Not Required
Charpy V notch Impact test at -30 Deg C. Acceptable value: 27J average and 20J individual		
1	126*	118*
2	118	90
3	110	108
4	94	110
5	88*	86*
Average value (J)	107	103

Note: ' \* ' - Indicates highest and lowest discarded values.

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**Chemical Analysis – Size 2.4 X 1000 mm**

	% C	% Cr	% Ni	% Mo	% Mn	% Si	% P	% S	% Cu	% Al	%Ti	%Zr
Range	0.07 Max	0.15Max	0.15Max	0.15 Max	0.9-1.4	0.40-0.70	0.025 Max	0.035 Max	0.50Max	0.05-0.15	0.05-0.15	0.02-0.12
Result	0.068	0.096	0.022	0.004	1.07	0.41	0.025	0.007	0.052	0.083	0.042	0.026

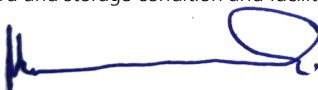

**Chemical Analysis – Size 3.15 X 1000 mm**

	% C	% Cr	% Ni	% Mo	% Mn	% Si	% P	% S	% Cu	% Al	%Ti	%Zr
Range	0.07 Max	0.15Max	0.15Max	0.15 Max	0.9-1.4	0.40-0.70	0.025 Max	0.035 Max	0.50Max	0.05-0.15	0.05-0.15	0.02-0.12
Result	0.069	0.065	0.018	0.005	1.06	0.43	0.016	0.008	0.097	0.11	0.057	0.043

Refer Radiography Report No. Global-013, results found acceptable.

The works of above manufacturer were inspected at the location stated and found in satisfactory order. The process of manufacture including supervision, quality control and record keeping were of adequate standard and storage condition and facilities were found to be satisfactory as well.

**Statement is Valid until 31 March 2024.**

  
  
Manish Trivedi  
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