



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

CAPITALE SOCIALE € 1.248.000 I.V. - 35013 CITTADILLA (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



Inspection Certificate 98376

Type INETIG D2 Client 301192 MIGATRONIC AS
 MIGA TIG KV2 SVEJSEMASKINEFABRIKKEN
 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

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.

This certificate is electronically generated and valid without signature.