

The Lincoln Electric Company  
 22801 St. Clair Avenue  
 Cleveland OH 44117



**Toughness Verification Test**

This is to state that the product indicated was tested according to the procedures shown. Mechanical properties and chemical analysis of the weld deposit were as shown.

**Innershield NR-233**

**C496R**

Diameter (in.): 1/16	Current Type & Polarity: DC-	Volts: 21	Shielding Gas: Not Applicable
Code: 9R27HE022	PHT (°F): 70	WFS (ipm): 195	Flow Rate (cfh): Not Applicable
Position: 3G-UP	INT (°F): 450	Amps: 220	
Thickness (in.): 0.75		Avg HI (kJ/in): 69.5	
		ESO (in): 0.875	

This product satisfies the requirements of FEMA 353, Appendix D after exposure for 8 weeks at 80°F, 80%RH.

<b>Charpy V-notch Test Results</b>	
Temp. (°F)	Energy (ft-lbf)
0	33
	32
	32
70	61
	60
	56

<b>Tensile Test Results</b>				
Aging	UTS (ksi)	YP (ksi)	YS (ksi)	EL (%)
48HRS@220F	86.4	66.8	64.4	22

<b>Chemical Test Results</b>						
C	S	Mn	Si	P	Al	Ni
0.210	<0.003	0.63	0.24	0.008	0.61	0.02

*Michael J. Morlock* June 6, 2003  
 Michael J. Morlock, Certification Supervisor

*David A. Fink* 6 June 2003  
 David A. Fink, Manager, Mature Products Consumable R&D

Fema Cert No.: FM-1002530

*This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of The Lincoln Electric Company affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.*