

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-232

PV591N

Diameter (in.): 0.068	Current Type & Polarity: DC-	Volts: 23	Shielding Gas: Not Applicable
Code: 6N28PAAD	PHT (°F): 500	WFS (ipm): 170	Flow Rate (cfh): Not Applicable
Position: 3G-up	INT (°F): 550	Amps: 260	
Thickness (in.): 0.75		Avg HI (kJ/in): 78.5	
		ESO (in): 0.625	

This product satisfies the requirements of FEMA 353, Appendix D after exposure for 1 week at 80°F, 80%RH.

Charpy V-notch Test Results

Temp. (°F)	Energy (ft-lbf)
0	54
	47
	43
72	80
	76
	72

Tensile Test Results

Aging	UTS (ksi)	YP (ksi)	YS (ksi)	EL (%)
48 hr. @ 220°F	79.8	63.2	61.4	30

Chemical Test Results

C	S	Mn	Si	P	Al	Ni
0.157	0.003	0.68	0.24	0.006	0.47	0.01

State of Ohio, County of Cuyahoga
 Subscribed and sworn to before me this

January, 2002
Lesiaesel
 Notary Public
 My commission expires September 23, 2004

Donald L. Bill, Certification Supervisor

David A. Fink, Manager, Mature Products Consumable R&D

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.