

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

C494RA

Diameter (in.): 1/16	Current Type & Polarity: DC-	Volts: 23	Shielding Gas: Not Applicable
Code: 9R27HE022	PHT (°F): 60	WFS (ipm): 245	Flow Rate (cfh): Not Applicable
Position: 1G	INT (°F): 250	Amps: 250	
Thickness (in.): 0.75		Avg HI (kJ/in): 30	
		ESO (in): 0.875	

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

Charpy V-notch Test Results	
Temp. (°F)	Energy (ft-lbf)
0	33
	30
	30
70	61
	58
	57

Tensile Test Results				
Aging	UTS (ksi)	YP (ksi)	YS (ksi)	EL (%)
48HRS@220F	92.2	77.3	71	26

Chemical Test Results						
C	S	Mn	Si	P	Al	Ni
0.212	<0.003	0.60	0.21	0.008	0.58	0.02

Michael J. Morlock June 5, 2003
 Michael J. Morlock, Certification Supervisor

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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.