



Indian Register of Shipping

Port: KANDLA
Date: 18.04.2017
Report No: KND17W001

(W) Electrode SME 7018 as described below, manufactured as per ASME SECTION II SECTION C, EDITION 2015

DESCRIPTION:

NAME OF MANUFACTURE	:M/S. SENOR METALS PVT. LTD.
TYPE OF ELECTRODE	:C.S. ELECTRODE FOR SMAW WELDING
BRAND NAME	:SME 7018
AWS CLASS	:SFA 5.1, E 7018
WELDING POSITION	:QUALIFIED FOR ALL POSITION
SIZE (mm)	:Ø 2.0 to Ø 5.0 mm
APPLICABLE CURRENT TYPE	:AC and DC +ve

Visual Inspection carried out , reviewed chemical analysis report, tensile test(Deposited weld), weld chemistry, Fillet weld testing witnesses and radiography film reviewed .All examined with satisfactory results.

Description of results as follows :

Required test as per ASME SECTION II PART "C" EDITION- 2015, SFA 5.1
Chemical Analysis:

Electrode Size (MM)	%C	%Mn	%Si	%P	%S	%Cr	%Ni	%Mo	%V	Mn +Ni +Cr +Mo+V
Req. Value	0.15	1.60	0.75	0.035	0.035	0.20	0.30	0.30	0.08	1.75
Dia 4.00 mm	0.090	1.17	0.48	0.026	0.008	0.022	0.009	0.004	0.012	1.22

Groove Weld for Soundness & Usability of Electrodes as per ASME SECTION II PART CEDITION-2015 – SFA 5.1

Electrode Size(MM)	Welding Position / Mechanical test / Radiography	Remark
Dia 4.00 mm	Tensile Test, Overhead(Fillet), Vertical(Fillet),Radiography Satisfactory	*Radiography Test report of No. AM /01668 & 1669 Dtd. 31.01.2017 of M/s. Accurate Metaweld Services.
Dia 5.00 mm	Horizontal (Fillet) Radiography Satisfactory	



S. K. Srijanya
(S.K.Srijanya)



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All Weld Metal Tension Test :

Electrode Size (MM)		Tensile Strength(Mpa)	Yield Strength at 0.2 % offset(Mpa)	Elongation (%)	Impact at - 30 Deg C
	Reqd. Value	490 min.	400 min.	22 %	27J Min
Dia.4.0 MM		552.07	482.25	31.88	32.66
Dia.5.0 MM		554.01	477.08	32.92	34.0

Diffusible Hydrogen & Moisture Test :

Electrode Size (MM)		Diffusible Hydrogen	Moisture
	Reqd. Value	4 ml / 100 gms of weld	0.30 max
4.0 mm	Observed value	2.297 ml per 100 gms of weld	0.067 %

“The validity of this certificate is subjected to annual approval being carried out every year by the society’s surveyor.”



(S.K.SIJARIYA & SANJEEV SHARMA)

Surveyor(s) to Indian Register of Shipping

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