



Phoenix Welding Wires

Plot No. C4, C5, C6, Radhe Industrial Estate,
Vadali Road, Taiyabpura,
Kapadwanj, 387 620
Gujarat (24)
GSTIN: 24ABCFP8783A1Z9

Test Certificate

for, MIG Wire for Gas Shielding Arc Welding of Structural Steels- Specification as per IS 6419:1996

Test Certificate No :- **PWW/BISTC/202425/ 1**

Date :- **01-04-2024**

We Certified that the material described below fully conforms to IS 6419:1996 chemical composition and Mechanical properties of the product, as tested in accordance with the Scheme of testing and inspection contained in the BIS Certification.

Size	Control Unit No.	Class	Chemical Composition											Condition (Finish, Temper, Cast, Helix)	Yield Strength	All Weld Metal Tensile Test	All weld metal Impact Test	Soundness	Dimensions and Tolerances	Remarks
			C %	Si %	Mn %	Ni %	Cr %	Mo %	S %	P %	V %	Zr %	Al %							
0.80mm	G42383	AWS-BFA-5.18 ER70S_6 IS:6419-64/DIN:8559-SG2	0.06-0.15	0.80-1.15	1.40-1.85	0.150 MAX	0.15 MAX	0.15 MAX	0.035 MAX	0.025 MAX	-	-	-	Cast :- 710mm	420 min.	500-640	27 Jule	Satisfactory	0.80mm	-
			0.080	0.900	1.480	0.018	0.027	0.002	0.004	0.014	0.001	-	0.004	Helix :- 08mm	443	562	63		(Tolerance :- -0.02mm)	

Remarks :-

Authorized Signatory,

Raj Patel

Phoenix Welding Wires

IS 6419:1996



CM/L : 7200242397



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			C %	Si %	Mn %	Ni %	Cr %	Mo %	S %	P %	V %	Zr %	Al %							
1.20mm	G42383	AWS-BFA-5.18 ER70S_6 IS:6419-64/DIN:8559-SG2	0.06-0.15	0.80-1.15	1.40-1.85	0.150 MAX	0.15 MAX	0.15 MAX	0.035 MAX	0.025 MAX	-	-	-	Cast :- 760mm Helix :- 9mm	420 min.	500-640	27 Jule	Satisfactory	1.20mm	-
			0.080	0.900	1.480	0.018	0.027	0.002	0.004	0.014	0.001	-	0.004		440	560	61		(Tolerance :- -0.02mm)	

Remarks :-

Authorized Signatory,

Raj Patel

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