



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/ 7

Date :-

02-09-2024

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)	Yeild 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	G46516	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 :- 550mm Helix :- 4 mm	420 mIn.	500-640	27 Jule	Satisfactory	0.80mm (Tolerance :- -0.02mm)	-
			0.070	0.860	1.470	0.020	0.019	0.002	0.003	0.011	0.001	-	0.004		442	569	49			

Authorized Signatory,




Phoenix Welding Wires

IS 6419:1996



CM/L : 7200242397

Mobile No. :- 820020 7299

www.phoenixweldingwires.com

info@phoenixweldingwires.com

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/ 7**

Date :- **02-09-2024**

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)	Yeild Strength	All Weld Metal Tensile Test	All weld metal Impact Test	Soundness	Dimension s and Tolerances	Remarks
			C %	Si %	Mn %	Ni %	Cr %	Mo %	S %	P %	V %	Zr %	Al %							
1.20mm	G46516	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 :- 600 mm Helix :- 3 mm	420 mIn.	500-640	27 Jule	Satisfactory	1.20mm (Tolerance :- -0.02mm)	-
			0.070	0.860	1.470	0.020	0.019	0.002	0.003	0.011	0.001	-	0.004		452	524	40			

Authorized Signatory,




Phoenix Welding Wires

IS 6419:1996



CM/L : 7200242397

Mobile No. :- 820020 7299

www.phoenixweldingwires.com

info@phoenixweldingwires.com