



The manufacturer – LLC «VITAPOLIS»

Silhostechnikum areastr. 16, 08150, Boyarka,
Fastivskyi district, Kiev region, Ukraine

Quality certificate № 231212-13

from 12.12.2023 p.

According to EN 10204 3.1

Lot number	4Si1-230015-20-088W
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Product name	TIG ROD
Brand	HORDA 4Si1
Diameter	2,0 мм
Weight	40 кг
ДСТУ EN ISO 14341	A-W 46 4 M21 4Si1
AWS A5.18	ER70S-6
ГОСТ 2246-70 (ДОВІДКОВО)	-

Welding conditions	Value
Welding current, A	
Are voltage, V	
<u>Shielding gas/Flux</u>	
The gas flow rate, l/min	
Electrode stick-out, mm	
Welding position	PA
Interpass temperature, °C	150

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380

Chemical analysis, (mass, %)	C	Si	Mn	P	S	Cr	Ni	Cu	Mo	N	Al	V	W	Ti
Wire/rod	0,070	0,970	1,650	0,017	0,010	0,030	0,020	0,030	0,005	-	0,004	-	-	0,004
Weld metal														

The testing laboratory of "VITAPOLIS" LLC is accredited by the National Accreditation Agency of Ukraine for testing in accordance with DSTU ISO/IEC 17025, accreditation certificate No. 201345 valid until August 10, 2027

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Customer:
Horus LLC

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Additional requirements of the customer	
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The test wire tensile Rm (MPa) -

All weld metal mechanical properties			
The test tensile			
Rm, (H/мм2)	Rt (0,2), (H/мм2)	A, (%)	Z, (%)
590	475	28	-

Impact test, KV			
	J, (+20°C)	J, (-40°C)	J, (-60°C)
1	151	113	
2	158	100	
3	160	108	
Δ	156	107	

The surface of the wire according to claim 3.26 GOST 2246-70	
The surface of the product according to claim 5.2 ISO 544:2019	answers

ГОВ «ВІТАПОЛІС»
Відповідає за
Inspector quality control
Технічний контроль
12.12.2023 p.
(дата)
БТК - 02
МП