

INSPECTION CERTIFICATE

KOBELCO WELDING OF EUROPE B.V.

FLUX CORED WIRE
According to EN 10204-3.1

PURCHASER _____

CERTIFICATE NO: KC21-157
DATE OF ISSUE: 03/05/2021

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-309L	1.2	N10510	AWS A5.22 E309LT0-1/4 EN ISO 17633-A T 23 12 L R C1/M21 3

1.CHEMICAL COMPOSITIONS OF ALL WELD METAL(wt%)

ELEMENT	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N		
WELD METAL	0.024	0.63	1.50	0.019	0.003	0.06	12.76	23.74	0.07	0.017		

ELEMENT			FS	FN		FNW						
WELD METAL			12.0	> 18		18.0						

FS:FERRITE CONTENT%(SCHAEFFLER DIAGRAM)
FN:FERRITE NUMBER(DELONG DIAGRAM)
FNW:FERRITE NUMBER(1992 WRC DIAGRAM)

2.TENSILE TEST OF ALL WELD METAL (ACCORDING TO ISO 17633)

YIELD STRENGTH at 0.2% OFFSET MPa	TENSILE STRENGTH MPa	ELONGATION GL=5D(%)
424	565	33

3.CHARPY IMPACT TEST OF ALL WELD METAL

TESTING TEMPERATURE (°C)	ABSORBED ENERGY (J)	
	EACH	AVERAGE

4.WELDING CONDITIONS FOR THE TESTING

TYPE OF CURRENT	DC+	SHIELDING GAS	80%Ar+20%CO2
WELDING CURRENT	200 (A)	ARC VOLTAGE	29.0 (V)

5.REMARKS

BISMUTH (Bi) CONTENT IN DEPOSITED METAL IS NO LESS THAN 0.002%.

WE HEREBY CERTIFY THAT THE TEST RESULTS OF THE ABOVE
WELDING MATERIAL ARE CORRECT



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QA Manager