

INSPECTION CERTIFICATE

KOBELCO WELDING OF EUROPE B.V.

FLUX CORED WIRE
According to EN 10204-3.1

PURCHASER _____

CERTIFICATE NO: KC20-255
DATE OF ISSUE: 29/05/2020

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-347LH	1.2	N0083011374	AWS A5.22 E347T1-1/4 EN ISO 17633-A T 19 9 Nb P C1/M21 2

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

ELEMENT	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N	Nb	
WELD METAL	0.03	0.60	1.68	0.024	0.002	0.05	10.19	18.18	0.01	0.025	0.66	
ELEMENT	V		FS	FN		FNW		Bi				
WELD METAL	0.06		5.0	5.0		5.0		0.0010				

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(%)
417	610	34

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	28.0 (V)

5.REMARKS

According to GofQ DW-347LH R0

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



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QA Manager