

INSPECTION CERTIFICATE

OF FLUX CORED WIRE FOR STAINLESS STEEL

According to EN 10204-3.1

PURCHASER _____

CERTIFICATE NO: KC20-393

DATE OF ISSUE: 23/09/2020

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-329AP	1.2	N0135010960	AWS A5.22 E2209T1-4 EN ISO 17633-A T 22 9 3 N L P M21 1

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

ELEMENT	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N	Nb	
WELD METAL	0.030	0.55	0.95	0.021	0.004	0.05	9.58	22.77	3.57	0.14	0.02	
ELEMENT	V					FNW						
WELD METAL	0.07					40.0						

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(%)
626	833	28

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%.
According to GofQ DW-329AP R1

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



KOBELCO WELDING OF EUROPE B.V.
QA Manager