

INSPECTION CERTIFICATE

FLUX CORED WIRE
According to EN 10204-3.1

PURCHASER _____

CERTIFICATE NO: KC20-398
DATE OF ISSUE: 29/09/2020

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-309LP	1.2	N01370	AWS A5.22 E309LT1-1/4 EN ISO 17633-A T 23 12 L P C1/M21 1

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

ELEMENT	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N	Nb	
WELD METAL	0.026	0.56	1.36	0.018	0.003	0.02	12.65	23.12	0.01	0.021	0.01	
ELEMENT	V		FS	FN		FNW						
WELD METAL	0.07		10.0	17.0		15.0						

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(%)
405	549	38

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

BISMUTH (Bi) CONTENT IN DEPOSITED METAL IS NO LESS THAN 0.002%.
According to GofQ DW-309LP R0

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



KOBELCO WELDING OF EUROPE B.V.

QA Manager