

# INSPECTION CERTIFICATE

**KOBELCO WELDING OF EUROPE B.V.**

FLUX CORED WIRE  
According to EN 10204-3.1

PURCHASER \_\_\_\_\_

CERTIFICATE NO: KC21-223

DATE OF ISSUE: 25/06/2021

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-308LP	1.2	N10860	AWS A5.22 E308LT1-1/4 EN ISO 17633-A T 19 9 L P C1/M21 1

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

ELEMENT	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N		
WELD METAL	0.030	0.80	1.79	0.021	0.002	0.11	9.76	19.39	0.08	0.020		

ELEMENT		FS	FN		FNW						
WELD METAL		9.0	12.0		10.0						

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(%)
380	574	41

3.CHARPY IMPACT TEST OF ALL WELD METAL

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

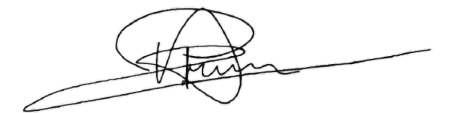
4.WELDING CONDITIONS FOR THE TESTING

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