

# INSPECTION CERTIFICATE

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

FLUX CORED WIRE

PURCHASER \_\_\_\_\_

CERTIFICATE NO: KC21-243

DATE OF ISSUE: 19/07/2021

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-329A	1.2	N10920	AWS A5.22 E2209T0-4 EN ISO 17633-A T 22 9 3 N L R M21 3

1.CHEMICAL COMPOSITIONS OF ALL WELD METAL(wt%), ACCORDING TO EN 10204-3.1

ELEMENT	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N		
WELD METAL	0.027	0.62	1.07	0.022	0.004	0.12	9.39	23.09	3.44	0.14		

ELEMENT						FNW						
WELD METAL						46.0						

FNW:FERRITE NUMBER(1992 WRC DIAGRAM)

2.TENSILE TEST OF ALL WELD METAL (ACCORDING TO EN ISO) ACCORDING TO EN 10204-3.1

YIELD STRENGTH at 0.2% OFFSET MPa	TENSILE STRENGTH MPa	ELONGATION GL=5D(%)
627	839	26

3.CHARPY IMPACT TEST OF ALL WELD METAL ACCORDING TO EN 10204-3.1

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	190 (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