

INSPECTION CERTIFICATE

OF FLUX CORED WIRE FOR STAINLESS STEEL

According to EN 10204-3.1

PURCHASER _____

CERTIFICATE NO: KC21-400

DATE OF ISSUE: 14/12/2021

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-329A	1.2	N11580	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%)

ELEMENT	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N		
WELD METAL	0.027	0.61	1.05	0.020	0.003	0.05	9.42	22.67	3.43	0.15		

ELEMENT						FNW						
WELD METAL						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(%)
622	832	27

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	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



KOBELCO WELDING OF EUROPE B.V.
QA Manager