KOBELCO WELDING OF EUROPE B.V.

INSPECTION CERTIFICATE

FLUX CORED WIRE

PURCHASER _____

CERTIFICATE NO: KC22-135

DATE OF ISSUE: 22/04/2022

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-307	1.2	N20550	EN ISO 17633-A T 18 8 Mn R M21 3

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

ELEMENT	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N	Nb	
WELD METAL	0.07	0.65	6.39	0.020	0.002	0.03	8.49	19.38	0.01	0.021	< 0.01	

ELEMENT			FS	FN		FNW						
WELD METAL			1.0	4.0		9.0						

FS:FERRITE CONTENT(%)(SCHAEFFLER DIAGRAM)
FN:FERRITE NUMBER(DELONG DIAGRAM)
FNW:FERRITE NUMBER(1992 WRC DIAGRAM)

2. MECHANICAL PROPERTY OF ALL WELD METAL (ACCORDING TO EN ISO)

2.a TENSILE TEST (ACCORDING TO EN 10204 TYPE 3.1)

YIELD STRENGTH at 0.2% OFFSET (MPa)	TENSILE STRENGTH (MPa)	ELONGATION GL=5D(%)
389	597	38

2.b CHARPY IMPACT (ACCORDING TO EN 10204 TYPE 3.1)

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

3. WELDING CONDITIONS FOR THE TESTING

TYPE OF CURRENT	DC+	SHIELDING GAS	80%Ar+20%CO2
WELDING CURRENT	190 (A)	ARC VOLTAGE	28.0 (V)

4. REMARKS

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

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QA Manager