

# INSPECTION CERTIFICATE

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

FLUX CORED WIRE

PURCHASER \_\_\_\_\_

CERTIFICATE NO: KC22-181

DATE OF ISSUE: 08/06/2022

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-329AP	1.2	N2073010960	AWS A5.22 E2209T1-4 EN ISO 17633-A T 22 9 3 N L P M21 1

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	0.023	0.60	0.90	0.020	0.002	0.05	9.48	22.69	3.42	0.15	0.01	
ELEMENT	V					FNW						
WELD METAL	0.11					41.0						

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(%)
594	815	29

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

BISMUTH (Bi) CONTENT IN DEPOSITED METAL IS NO LESS THAN 0.002%.  
According to GofQ DW-329AP R1

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



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QA Manager