

# INSPECTION CERTIFICATE

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

FLUX CORED WIRE

PURCHASER \_\_\_\_\_

CERTIFICATE NO: KC22-231

DATE OF ISSUE: 27/07/2022

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-309L	1.2	N20980	AWS A5.22 E309LT0-1/4 EN ISO 17633-A T 23 12 L R C1/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		
WELD METAL	0.027	0.63	1.59	0.019	0.003	0.13	12.57	24.32	0.05	0.023		

  

ELEMENT			FS	FN		FNW						
WELD METAL			14.0	> 18		21.0						

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(%)
394	558	36

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	210 (A)	ARC VOLTAGE	28.0 (V)

4. 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