

INSPECTION CERTIFICATE

KOBELCO WELDING OF EUROPE B.V.

FLUX CORED WIRE

PURCHASER _____

CERTIFICATE NO: KC22-257

DATE OF ISSUE: 25/08/2022

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-2594	1.2	N21130	AWS A5.22 E2594T1-1/4 EN ISO 17633-A T 25 9 4 N L P C1/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	0.026	0.47	1.18	0.016	0.003	0.04	9.52	25.57	3.67	0.23	0.01	
ELEMENT	V					FNW	PRE					W
WELD METAL	0.09					50.0	41.4					0.0

FNW:FERRITE NUMBER(1992 WRC DIAGRAM)
PRE:Cr+3.3xMo+16xN

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(%)
671	883	31

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

TESTING TEMPERATURE (°C)	ABSORBED ENERGY(J)		
	EACH		AVERAGE
-40	40	37	41
			39

3. WELDING CONDITIONS FOR THE TESTING

TYPE OF CURRENT	DC+	SHIELDING GAS	80%Ar+20%CO2
WELDING CURRENT	190 (A)	ARC VOLTAGE	29.0 (V)

4. REMARKS

According to GofQ DW-2594 R0

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



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QA Manager