

INSPECTION CERTIFICATE

KOBELCO WELDING OF EUROPE B.V.

FLUX CORED WIRE

PURCHASER _____

CERTIFICATE NO: KC22-292

DATE OF ISSUE: 16/09/2022

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-312	1.2	N21230	EN ISO 17633-A T 29 9 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	Ti
WELD METAL	0.12	0.84	1.35	0.016	0.001	0.05	9.95	28.67	0.03	0.014	< 0.01	0.02

ELEMENT						FNW						
WELD METAL						53						

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(%)
542	746	25

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	200 (A)	ARC VOLTAGE	29.0 (V)

4. REMARKS

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



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QA Manager