KOBELCO WELDING OF EUROPE B.V.

INSPECTION CERTIFICATE

FLUX CORED WIRE

PURCHASER _____

CERTIFICATE NO: KC23-104

DATE OF ISSUE: 12/04/2023

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-309MoLP	1.2	N30410	AWS A5.22 E309LMoT1-1/4 EN ISO 17633-A T 23 12 2 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	0.030	0.67	0.92	0.022	0.003	0.07	12.66	22.22	2.30	0.017	0.01	

ELEMENT	V		FS	FN		FNW						
WELD METAL	0.05		15.0	> 18		22.0						

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(%)
514	697	31

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%.
According to GofQ DW-309MoLP R0

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

KOBELCO WELDING OF EUROPE B.V.
QA Manager