

# INSPECTION CERTIFICATE

FLUX CORED WIRE

KOBELCO WELDING OF EUROPE B.V.

PURCHASER \_\_\_\_\_

CERTIFICATE NO: KC23-148

DATE OF ISSUE: 17/05/2023

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION			
DW-309L	1.2	N30610	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	0.53	1.41	0.019	0.003	0.05	12.24	23.69	0.03	0.021
ELEMENT	FS	FN	FS	FN	FNW	FNW				
WELD METAL	13.0	> 18			20.0					

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(%)
421	569	33

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%A+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



KOBELCO WELDING OF EUROPE B.V.  
QA Manager