

INSPECTION CERTIFICATE

FLUX CORED WIRE

PURCHASER _____

CERTIFICATE NO: KC23-374

DATE OF ISSUE: 18/12/2023

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION	
DW-308LP	1.2	N31710	AWS A5.22 E308LT1-1/4 EN ISO 17633-A T 19 9 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
WELD METAL	0.024	0.66	1.64	0.022	0.004	0.04	9.89	19.06	0.02	0.022
ELEMENT	FS		FN	FNW		FNW		FNW		
WELD METAL	8.0		10.0	8.0		8.0		8.0		

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(%)
369	569	40

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	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