

# INSPECTION CERTIFICATE

**KOBELCO WELDING OF EUROPE B.V.**

FLUX CORED WIRE

PURCHASER \_\_\_\_\_

CERTIFICATE NO: KC24-192

DATE OF ISSUE: 03/06/2024

| TRADE DESIGNATION | DIAMETER (mm) | MFG.NO. | APPLICABLE SPECIFICATION AND CLASSIFICATION                    |
|-------------------|---------------|---------|--|
| DW-316L           | 1.2           | N40800  | AWS A5.22 E316LT0-1/4<br>EN ISO 17633-A T 19 12 3 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     | Nb     |  |
|------------|-------|------|------|-------|-------|------|-------|-------|------|-------|--------|--|
| WELD METAL | 0.024 | 0.63 | 1.72 | 0.025 | 0.003 | 0.06 | 12.09 | 18.70 | 2.67 | 0.019 | < 0.01 |  |
| ELEMENT    | V     |      | FS   | FN    |       | FNW  |       |       |      |       |        |  |
| WELD METAL | 0.05  |      | 8.0  | 12.0  |       | 9.0  |       |       |      |       |        |  |

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<br>at 0.2% OFFSET<br>(MPa) | TENSILE<br>STRENGTH<br>(MPa) | ELONGATION<br>GL=5D(%) |
|---|------------------------------|------------------------|
| 389                                       | 560                          | 36                     |

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

| TESTING<br>TEMPERATURE<br>(°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-316L R0

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

*H. Sugahara*

KOBELCO WELDING OF EUROPE B.V.  
QA Manager