

INSPECTION CERTIFICATE

KOBELCO WELDING OF EUROPE B.V.

FLUX CORED WIRE

PURCHASER _____ CERTIFICATE NO: KC24-334
 DATE OF ISSUE: 01/10/2024

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION	
DW-316L	1.2	N41520	AWS A5.22 E316LT0-1/4 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	0.021	0.62	1.72	0.023	0.004	0.08	12.24	18.56	2.79	0.026	< 0.01
ELEMENT	V	FS	FN	FNW	FNW	FNW	FNW	FNW	FNW	FNW	FNW
WELD METAL	0.05	7.0	11.0	9.0	9.0	9.0	9.0	9.0	9.0	9.0	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 at 0.2% OFFSET (MPa)	TENSILE STRENGTH (MPa)	ELONGATION GL=5D(%)
418	563	37

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

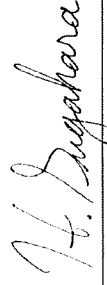
TESTING TEMPERATURE (°C)	ABSORBED ENERGY(J)
	EACH
	AVERAGE

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%.
 According to GofQ DW-316L R0

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



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 QA Manager