

# INSPECTION CERTIFICATE

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

FLUX CORED WIRE

PURCHASER \_\_\_\_\_ CERTIFICATE NO: KC24-362  
 DATE OF ISSUE: 25/10/2024

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-316L	1.2	N41690	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	0.023	0.50	1.66	0.023	0.004	0.06	12.20	18.72	2.68	0.022	< 0.01
ELEMENT	V	FS	FN	FNW	FNW	FNW	FNW	FNW	FNW	FNW	FNW
WELD METAL	0.06	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(%)
379	534	39

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

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

BISMUJTH (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

*A. Sugahara*

KOBELCO WELDING OF EUROPE B.V.  
QA Manager