

INSPECTION CERTIFICATE

KOBELCO WELDING OF EUROPE B.V.

FLUX CORED WIRE

PURCHASER _____

CERTIFICATE NO: KC24-391

DATE OF ISSUE: 18/11/2024

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-329A	1.2	N4177010998	AWS A5.22 E2209T0-4 EN ISO 17633-A T 22 9 3 N L R 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	0.030	0.69	1.13	0.022	0.003	0.06	9.13	23.49	3.35	0.14		

ELEMENT						FNW						
WELD METAL						52.0						

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(%)
663	846	27

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

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

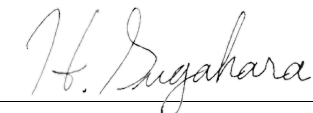
3. WELDING CONDITIONS FOR THE TESTING

TYPE OF CURRENT	DC+	SHIELDING GAS	80%Ar+20%CO2
WELDING CURRENT	200 (A)	ARC VOLTAGE	29.0 (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