

INSPECTION CERTIFICATE

OF FLUX CORED WIRE FOR STAINLESS STEEL

According to EN 10204-3.1

PURCHASER _____ CERTIFICATE NO: KC17-071
 DATE OF ISSUE: 02/02/2017

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION									
DW-329AP	1.2	N7017010960	AWS A5.22 E2209T1-4 EN ISO 17633-A T 22 9 3 N L P M21 1									

1. CHEMICAL COMPOSITIONS OF ALL WELD METAL (wt%)

ELEMENT	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N	Nb
WELD METAL	0.026	0.48	0.80	0.020	0.003	0.04	9.31	22.93	3.54	0.13	0.02
ELEMENT	V					FNW					
WELD METAL	0.08					49.2					

FNW:FERRITE NUMBER(1992 WRC DIAGRAM)

2. TENSILE TEST OF ALL WELD METAL (ACCORDING TO ISO 17633)

YIELD STRENGTH at 0.2% OFFSET N/mm ²	TENSILE STRENGTH N/mm ²	ELONGATION GL=5D(%)
627	812	27

3. CHARPY IMPACT TEST OF ALL WELD METAL

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

4. WELDING CONDITIONS FOR THE TESTING

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

5. 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