

INSPECTION CERTIFICATE

KOBELCO WELDING OF EUROPE B.V.

FLUX CORED WIRE

PURCHASER _____

CERTIFICATE NO: KC23-114
DATE OF ISSUE: 13/04/2023

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-A55L	1.2	NB3422	AWS A5.29 E81T1-K2M EN ISO 17632-A - T 46 6 1.5Ni P M 1 H5

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	V	Nb
WELD METAL	0.05	0.33	1.17	0.006	0.007	0.01	1.42	0.02	0.01	0.02	< 0.01
ELEMENT											
WELD METAL											

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(%)
558	624	22

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

TESTING TEMPERATURE (°C)	ABSORBED ENERGY(J)	
	EACH	AVERAGE
-60	98	104

3. WELDING CONDITIONS FOR THE TESTING

TYPE OF CURRENT	DC+	SHIELDING GAS	80%Ar+20%CO2
WELDING CURRENT	240 (A)	ARC VOLTAGE	29.0 (V)

4. REMARKS

ACCORDING TO GofQ DW-A55L R2

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



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QA Manager