

INSPECTION CERTIFICATE

FLUX CORED WIRE

PURCHASER _____

CERTIFICATE NO: KC24-165
DATE OF ISSUE: 16/05/2024

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-A55E	1.2	NC453113658	AWS A5.20 E71T-9M-J EN ISO 17632-A - T 46 4 P M 1 H5

1. CHEMICAL COMPOSITIONS OF ALL WELD METAL(WP%) (ACCORDING TO EN 10204 TYPE 3.1)

ELEMENT	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb
WELD METAL	0.04	0.61	1.31	0.012	0.012	0.02	0.38	0.03	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(%)
525	586	26

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

TESTING TEMPERATURE (°C)	ABSORBED ENERGY(J) EACH	AVERAGE
-40	132 112 129	124

3. WELDING CONDITIONS FOR THE TESTING

TYPE OF CURRENT	DC+	SHIELDING GAS	80%Ar+20%CO2
WELDING CURRENT	280 (A)	ARC VOLTAGE	31.0 (V)

4. REMARKS
ACCORDING TO GofQ DW-A55E R2

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

A. Sugahara

KOBELCO WELDING OF EUROPE B.V.
QA Manager