

INSPECTION CERTIFICATE

KOBELCO WELDING OF EUROPE B.V.

FLUX CORED WIRE

PURCHASER _____

CERTIFICATE NO: KC22-153

DATE OF ISSUE: 04/05/2022

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-A55L	1.2	ND2442	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	1.14	0.007	0.007	0.02	1.58	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(%)
555	624	24

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

TESTING TEMPERATURE (°C)	ABSORBED ENERGY(J)			AVERAGE
	EACH			
-60	118	105	108	110

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