

# INSPECTION CERTIFICATE

**KOBELCO WELDING OF EUROPE B.V.**

FLUX CORED WIRE

PURCHASER \_\_\_\_\_

CERTIFICATE NO: KC24-413

DATE OF ISSUE: 02/12/2024

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-A55E	1.2	ND4B4313658	AWS A5.20 E71T-9M-J EN ISO 17632-A - T 46 4 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	0.04	0.57	1.23	0.007	0.006	0.02	0.39	0.02	0.00	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(%)
543	581	26

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

TESTING TEMPERATURE (°C)	ABSORBED ENERGY(J)		
	EACH	AVERAGE	
-40	121	143	137
	134		

3. WELDING CONDITIONS FOR THE TESTING

TYPE OF CURRENT	DC+	SHIELDING GAS	80%Ar+20%CO2
WELDING CURRENT	270	(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

*H. Sugahara*

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QA Manager