

INSPECTION CERTIFICATE

KOBELCO WELDING OF EUROPE B.V.

FLUX CORED WIRE
According to EN 10204-3.1

PURCHASER _____

CERTIFICATE NO: **KC14-386**

DATE OF ISSUE: **19/06/2014**

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-50	1.2	ND454413655	SFA/AWS A5.20 E71T-1C EN ISO 17632-A - T 42 2 P C/M 1 H5

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

ELEMENT	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb
WELD METAL	0.038	0.65	1.30	0.008	0.006	0.01	0.01	0.03	0.01	0.023	< 0.01
ELEMENT											
WELD METAL											

2.TENSILE TEST OF ALL WELD METAL

YIELD STRENGTH at 0.2% OFFSET N/mm2	TENSILE STRENGTH N/mm2	ELONGATION GL=5D(%)
497	572	27


3.CHARPY IMPACT TEST OF ALL WELD METAL

TESTING TEMPERATURE (°C)	ABSORBED ENERGY (J)			AVERAGE
	EACH	EACH	EACH	
-20	72	111	114	99
-30	60	48	72	60

4.WELDING CONDITIONS FOR THE TESTING

TYPE OF CURRENT	DC+	SHIELDING GAS	100% CO2
WELDING CURRENT	245 (A)	ARC VOLTAGE	29.0 (V)

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



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QA Manager