

INSPECTION CERTIFICATE

KOBELCO WELDING OF EUROPE B.V.

FLUX CORED WIRE
According to EN 10204-3.1

PURCHASER _____

CERTIFICATE NO: **KC14-388**

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

TRADE DESIGNATION	DIAMETER (mm)	MFG.NO.	APPLICABLE SPECIFICATION AND CLASSIFICATION
DW-A50	1.2	NF466113666	AWS A5.20 E71T-1M EN ISO 17632-A - T 42 2 P 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	0.044	0.55	1.41	0.008	0.008	0.01	0.01	0.03	0.01	0.024	< 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(%)
525	586	28

3.CHARPY IMPACT TEST OF ALL WELD METAL

TESTING TEMPERATURE (°C)	ABSORBED ENERGY (J)			AVERAGE
	EACH			
-20	124	128	127	126

4.WELDING CONDITIONS FOR THE TESTING

TYPE OF CURRENT	DC+	SHIELDING GAS	80%Ar+20%CO2
WELDING CURRENT	280 (A)	ARC VOLTAGE	32.0 (V)

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



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QA Manager