



Certificate for Welding Consumable CM-2CW

Project: **Supplementary List of Certified Welding Consumables**

Client: **Kobe Steel, Ltd.
Ibaraki Plant**

Office: **Yokohama**

Clients Order Number: -

Date: **19 June 2020**

Order Status: **Completed**

Inspection Dates

First: **21 February 2020**

Final: **15 May 2020**

This certificate is issued to the above Client to certify that the undersigned Surveyor to this Society did at their request attend their Ibaraki Plant and Fujisawa Plant on and between the dates shown above for the purpose of examining and testing below noted welding consumable.

Trade Name: **CM-2CW**
Welding Process: **Manual Electrode**
Welding Position: **DXVuO**
Joint Type: **BF**
Specification: **CM-2CW [M – Manufacturer's specification]**

A weld metal assembly was prepared using the welding consumable of lot number A008987S, and specimens machined from the assembly according to the specification were tested using calibrated measuring and testing equipment in the presence of the undersigned with results satisfying the requirements of the specification as follows.

Stress Relief Condition 1

Mechanical Properties of Deposit Metal

	Dia. [mm]	Re [N/mm ²]	Rm [N/mm ²]	A [%]	CVN Impact [J]	Test Temp.	Stress Relief
Spec.	2.6-5.0	≥ 530	≥ 620	≥ 17	-	-	715°C x 2hrs
Obtained	4.0	634	721	22	-	-	715°C x 2hrs

Chemical Analysis of Deposit Metal [WT %]

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Spec.	0.15 max	0.60 max	0.10-1.60	0.020 max	0.010 max	-	1.90-2.60	0.05-0.85	-
Obtained	0.05	0.39	0.94	0.006	0.004	-	2.44	0.07	-

Stress Relief Condition 2

Mechanical Properties of Deposit Metal

	Dia. [mm]	Re [N/mm ²]	Rm [N/mm ²]	A [%]	CVN Impact [J]	Test Temp.	Stress Relief
Spec.	2.6-5.0	≥ 400	≥ 510	≥ 17	-	-	715°C x 1hr
Obtained	4.0	665	748	23	-	-	715°C x 1hr

Chemical Analysis of Deposit Metal [WT %]

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Spec.	0.15 max	0.60 max	0.10-1.60	0.020 max	0.010 max	-	1.90-2.60	0.05-0.85	-
Obtained	0.05	0.39	0.94	0.006	0.004	-	2.44	0.07	-

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The works of the manufacturer was inspected and found in satisfactory order. The process of manufacture, including supervision, quality control and record keeping were of adequate standard and storage condition and facilities were found to be satisfactory as well.



S. Kato
Surveyor to Lloyd's Register Group Limited



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