



Certificate for Welding Consumable US-255/PF-H55LT

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

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

Office: **Yokohama**

Clients Order Number: -

Date: **21 August 2020**

Order Status: **Completed**

Inspection Dates

First: **29 June 2020**

Final: **29 June 2020**

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

Trade Name: **US-255/PF-H55LT**
Welding Process: Solid Wire/Flux
Welding Position: D
Joint Type: B
Specification: US-255/PF-H55LT [M – Manufacturer's specification]

A weld metal assembly was prepared using the welding consumable of lot number GZ80297 / 0ARQ010, 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.

Mechanical Properties of Deposit Metal & Butt Weld

	Dia. [mm]	Re [N/mm ²]	Rm [N/mm ²]	EL [%]	Trans Butt [N/mm ²]	CVN Impact [J]	Test Temp.
Spec.	4.0 to 4.8	≥ 375	490-660	≥ 22	≥ 490	≥ 34	-60°C
Obtained	4.8	530	619	22	511	37/38/50, Ave.42	-60°C

Chemical Analysis of Deposit Metal [WT %]

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	Ti	B
Spec.	0.16 max	0.10-0.50	1.00-2.00	0.030max	0.030max	0.10-1.50	-	0.10-0.40	0.35 max	0.005-0.040	0.001-0.005
Obtained	0.07	0.23	1.36	0.007	0.001	0.72	-	0.17	0.04	0.015	0.003

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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