



Certificate for Welding Consumable US-511/G-80

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

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

Office: **Yokohama**

Clients Order Number: -

Date: **16 June 2020**

Order Status: **Completed**

Inspection Dates

First: **28 January 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 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-511/G-80**
Welding Process: Solid Wire/Flux (SAW)
Welding Position: D
Joint Type: B
Specification: US-511/G-80 [M – Manufacturer's specification]

A weld metal assembly was prepared using the welding consumable/flux of lot number G8B9921/9BNF101, 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

	Dia. [mm]	Re [N/mm ²]	Rm [N/mm ²]	A [%]	CVN Impact [J]	Test Temp.	Stress Relief
Spec.	4.0 to 4.8	≥ 400	490-660	≥ 22	-	-	690°Cx1hr
Obtained	4.0	475	592	25	-	-	690°Cx1hr

Chemical Analysis of Deposit Metal [WT %]

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Spec.	0.05-0.15	0.80 max	1.20 max	0.030 max	0.030 max	-	1.00-1.50	0.40-0.65	-
Obtained	0.09	0.29	1.14	0.008	0.002	-	1.36	0.55	-

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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