



# 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: **01 July 2024**

Order Status: **Completed**

Inspection Dates

First: **21 February 2024**

Final: **17 May 2024**

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 A0581Z79, 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 <sup>2</sup> ]	Rm [N/mm <sup>2</sup> ]	A [%]	CVN Impact [J]	Test Temp.	Stress Relief
<b>Spec.</b>	2.6-5.0	≥ 530	≥ 620	≥ 17	-	-	715°C x 2hrs
<b>Obtained</b>	4.0	633	719	23	-	-	715°C x 2hrs

### Chemical Analysis of Deposit Metal [WT %]

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
<b>Spec.</b>	0.15 max	0.60 max	0.10-1.60	0.020 max	0.010 max	-	1.90-2.60	0.05-0.85	-
<b>Obtained</b>	0.05	0.38	0.88	0.004	0.003	-	2.49	0.08	-

## Stress Relief Condition 2

### Mechanical Properties of Deposit Metal

	Dia. [mm]	Re [N/mm <sup>2</sup> ]	Rm [N/mm <sup>2</sup> ]	A [%]	CVN Impact [J]	Test Temp.	Stress Relief
<b>Spec.</b>	2.6-5.0	≥ 400	≥ 510	≥ 17	-	-	715°C x 1hr
<b>Obtained</b>	4.0	646	729	21	-	-	715°C x 1hr

### Chemical Analysis of Deposit Metal [WT %]

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
<b>Spec.</b>	0.15 max	0.60 max	0.10-1.60	0.020 max	0.010 max	-	1.90-2.60	0.05-0.85	-
<b>Obtained</b>	0.05	0.38	0.88	0.004	0.003	-	2.49	0.08	-

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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.



M. Wakamori  
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