VdTÜV-Kennblatt for welding consumables

	1 Manufacturer/Supplier Kobelco Welding of Europe B.V. with manufacturer's works according to VdTÜV list 1000	2 No. of VdTÜV-Kennblatt: 10696.04 05.2009

3 Welding consumable*:	Fülldrahtelektrode
4 Trade name*:	DW-309LP
7 Type*:	EN ISO 17633-A T 23 12 L P M 1
11 Diameter range:	1,2 mm
12 Auxiliary materials:	EN ISO 14175 - M21

13 The validity of this Kennblatt will be certified,respectively, in the latest edition of CD-ROM TÜV-eignungsgeprüfte Schweißzusätze

15 Materials and postweld heat treatment

Pos	Wb	Group / Material 1	Text	Group / Material 2	Remarks
	U	Gruppe 8.1 (ohne Mo)	verschweißt mit	Gruppe 1.1; 1.2	

16 Material groups acc. to CR ISO 15608

21 Root weldability:	verified
23 Wall thickness:	40
24 Type of current and polarity:	G+
25 Welding position according to DIN ISO 6947:	PA, PB, PC, PD, PE, PF
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:	350°C
27 Highest operating temperature in the long-term range max.:	---°C
28 Lowest operating temperature/as for parent metal, but not lower than:	-60°C
29 Design stress value/as for parent metal:	wie Grundwerkstoff
30 For use in the long-term range:	--
31 Resistance to intergranular corrosion proven in accordance with:	--

32 Remarks:
Wurzelschweißbarkeit auf Keramikunterlage nachgewiesen.

33 The approval test was done on the basis of VdTÜV-Merkblatt 1153.Where nothing different is said under the heading -Remarks-, this welding consumable is suitable provided Annex I Point 4 of the Pressure Equipment Directive 97/23/EC is observed.

34 Explanations				
	A tempered	S stress-relieved	W soft annealed	G+ direct current plus pole
	L solution annealed and quenched	St stabilized		G- direct current minus pole
	N normalized	U non-annealed		W alternating current
		V hardened and tempered		

35 Compiled in accordance with the data of: TÜV Rheinland

*) Statements of the manufacturer