

# TÜV-Verband Welding Consumable Leaflet

## according to TÜV-Verband Technical Leaflet 1153 and DIN EN 14532

|                                                                                                                                                                                                                                                                                                                                        |    |                                                                                                                           |                                                                                 |                    |                                                                                      |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----|---------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------|--------------------|--------------------------------------------------------------------------------------|--|
|                                                                                                                                                                                                                                                       |    | 1 Manufacturer/Supplier<br>Kobelco Welding of Europe B.V.<br>with manufacturer's works according to TÜV-Verband List 1000 |                                                                                 |                    | 2 Number:<br>07366.06<br>03.06.2026                                                  |  |
| 3 Welding consumable*:                                                                                                                                                                                                                                                                                                                 |    | Fülldrahtelektrode                                                                                                        |                                                                                 |                    |                                                                                      |  |
| 4 Trade name*:                                                                                                                                                                                                                                                                                                                         |    | DW-309L                                                                                                                   |                                                                                 |                    |                                                                                      |  |
| 7 Type*:                                                                                                                                                                                                                                                                                                                               |    | EN ISO 17633 - A T 23 12 L R C1/M21 3                                                                                     |                                                                                 |                    |                                                                                      |  |
| 11 Diameter range:                                                                                                                                                                                                                                                                                                                     |    | 1,2 bis 1,6 mm                                                                                                            |                                                                                 |                    |                                                                                      |  |
| 12 Auxiliary materials:                                                                                                                                                                                                                                                                                                                |    | EN ISO 14175 - M21, C1                                                                                                    |                                                                                 |                    |                                                                                      |  |
| 13 The validity is certified by the appearance of the welding consumable leaflet in the welding consumables portal.                                                                                                                                                                                                                    |    |                                                                                                                           |                                                                                 |                    |                                                                                      |  |
| 15 Materials and postweld heat treatment                                                                                                                                                                                                                                                                                               |    |                                                                                                                           |                                                                                 |                    |                                                                                      |  |
| Pos                                                                                                                                                                                                                                                                                                                                    | Wb | Group / Material 1                                                                                                        | Text                                                                            | Group / Material 2 | Remarks                                                                              |  |
|                                                                                                                                                                                                                                                                                                                                        | U  | Gruppe 8.1                                                                                                                | verschweißt mit                                                                 | Gruppe 1.2         |                                                                                      |  |
| 16 Material groups acc. to CR ISO 15608                                                                                                                                                                                                                                                                                                |    |                                                                                                                           |                                                                                 |                    |                                                                                      |  |
| 21 Root weldability:                                                                                                                                                                                                                                                                                                                   |    | verified                                                                                                                  |                                                                                 |                    |                                                                                      |  |
| 23 Wall thickness:                                                                                                                                                                                                                                                                                                                     |    | maximal 30 mm                                                                                                             |                                                                                 |                    |                                                                                      |  |
| 24 Type of current and polarity:                                                                                                                                                                                                                                                                                                       |    | G+                                                                                                                        |                                                                                 |                    |                                                                                      |  |
| 25 Welding position according to DIN EN ISO 6947:1997-05: PA, PB, PC, PD, PE, PF                                                                                                                                                                                                                                                       |    |                                                                                                                           |                                                                                 |                    |                                                                                      |  |
| 26 Highest operating temperature in the short-term range as for parent metal, but not higher than:                                                                                                                                                                                                                                     |    |                                                                                                                           |                                                                                 | 300 °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 :                                                                                                                                                                                                                                                                                                                           |    |                                                                                                                           |                                                                                 |                    |                                                                                      |  |
| 33 The approval test for the welding consumable was carried out on the basis of TÜV-Verband Technical Leaflet 1153 and DIN EN 14532. If no conflicting test principles are stated under heading 32 – Remarks –, this welding consumable is suitable for use according to the Pressure Equipment Directive 2014/68/EU, Annex I Point 4. |    |                                                                                                                           |                                                                                 |                    |                                                                                      |  |
| 34 Explanations                                                                                                                                                                                                                                                                                                                        |    | A tempered<br>L solution annealed and quenched<br>N normalized                                                            | S stress-relieved<br>St stabilized<br>U non-annealed<br>V hardened and tempered | W soft annealed    | G+ direct current plus pole<br>G- direct current minus pole<br>W alternating current |  |
| 35 Compiled in accordance with the data of:                                                                                                                                                                                                                                                                                            |    |                                                                                                                           |                                                                                 | TÜV Rheinland      |                                                                                      |  |
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\*) Statements of the manufacturer