

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: 07368.08 05.2009																
3 Welding consumable*: Fülldrahtelektrode																		
4 Trade name*: DW-309MoL																		
7 Type*: EN ISO 17633-A T 23 12 2 L R C/M 3																		
11 Diameter range: 1,2 bis 1,6 mm																		
12 Auxiliary materials: EN ISO 14175 - M21, C1																		
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																		
1. U: X 10 CrNiMoNb 18 12 (1.4583) verschweißt mit: P195GH , P265GH , P295GH , P355N 2. U: X 2 CrNiMoN 22 5 3 (1.4462) n. VdTÜV-Werkstoffblatt 418 verschweißt mit: P195GH , P265GH , P295GH , P355N 3. Schweißplattierungen U: Für die erste Lage von korrosionsbeständigen Schweißplattierungen an: P195GH , P265GH , P295GH , P355N																		
16 Material groups acc. to CR ISO 15608																		
21 Root weldability: not verified																		
23 Wall thickness: maximal 30 mm (1)																		
24 Type of current and polarity: G+																		
25 Welding position according to DIN ISO 6947: PA, PB, PC, PF																		
26 Highest operating temperature in the short-term range as for parent metal, but not higher than: (2) 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: -10°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: (1) Unbegrenzt für die Trägerwerkstoffe bei Schweißplattierungen, soweit keine Wärmebehandlung für die Grundwerkstoffe erforderlich wird. (2) Für Schweißverbindungen mit 1.4462 maximal 250°C. Zu Wurzelschweißbarkeit: Nur mit keramischer Schweißbadsicherung 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 <table style="width:100%; border:none;"> <tr> <td style="width:25%;">A tempered</td> <td style="width:25%;">S stress-relieved</td> <td style="width:25%;">W soft annealed</td> <td style="width:25%;">G+ direct current plus pole</td> </tr> <tr> <td>L solution annealed and quenched</td> <td>St stabilized</td> <td></td> <td>G- direct current minus pole</td> </tr> <tr> <td>N normalized</td> <td>U non-annealed</td> <td></td> <td>W alternating current</td> </tr> <tr> <td></td> <td>V hardened and tempered</td> <td></td> <td></td> </tr> </table>			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		
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35 Compiled in accordance with the data of: TÜV Rheinland																		
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*) Statements of the manufacturer