


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: 10698.06 03.2014	
3 Welding consumable*:		Fülldrahtelektrode				
4 Trade name*:		DW-329A				
7 Type*:		EN ISO 17633-A T 22 9 3 N L R M 3				
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	Gruppen 8.1; 10.1				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		verified				
23 Wall thickness:		max. 40mm				
24 Type of current and polarity:		G+				
25 Welding position according to DIN ISO 6947:		PA, PB, PC, PD, PF				
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:		250°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:		EN ISO 3651-2				
32 Remarks: Zu Zeile 21. Wurzelschweißbarkeit wurde nur 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 L solution annealed and quenched N normalized	S stress-relieved St stabilized U non-annealed V hardened and tempered	W soft annealed	G+ direct current plus pole G- direct current minus pole W alternating current	
35 Compiled in accordance with the data of:		TÜV Rheinland				
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*) Statements of the manufacturer