


# VdTÜV-Kennblatt for welding consumables

|  |    |   |   |                    |  |         |
|--|----|---|---|--------------------|--|---------|
|   |    | 1 Manufacturer/Supplier<br>Kobelco Welding of Europe B.V.<br>with manufacturer's works according to VdTÜV list 1000 |   |                    | 2 No. of<br>VdTÜV-Kennblatt:<br>12135.04<br>17.10.2018                               |         |
| 3 Welding consumable*:   |    | Fülldrahtelektrode  |   |                    |  |         |
| 4 Trade name*:   |    | DW-347LH  |   |                    |  |         |
| 7 Type*:   |    | EN ISO 17633-A - T 19 9 Nb P M,C  |   |                    |  |         |
| 11 Diameter range:   |    | 1,2 - 1,6 mm  |   |                    |  |         |
| 12 Auxiliary materials:  |    | EN ISO 14175 - M2, M3, C  |   |                    |  |         |
| 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)  |   |                    |  |         |
| 16 Material groups acc. to CR ISO 15608  |    |   |   |                    |  |         |
| 21 Root weldability:   |    | verified  |   |                    |  |         |
| 23 Wall thickness:   |    | max. 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:   |    |   |   |                    |  | 400°C   |
| 27 Highest operating temperature in the long-term range max.:  |    |   |   |                    |  | ---- °C |
| 28 Lowest operating temperature/as for parent metal, but not lower than:   |    |   |   |                    |  | -196°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:<br>Zu Zeile 21: Die Eignung zur Wurzelschweißung auf keramische Badsicherung wurde nachgewiesen. Die 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<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