TÜV-Verband Welding Consumable Leaflet

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

TÜV VERBAND	1 Manufacturer/Supplier Kobelco Welding of Europe B.V. with manufacturer's works according to TÜV-Verband list 1000	2 Number: 12135.05 03.06.2026

3 Welding consumable*:	Fülldrahtelektrode
4 Trade name*:	DW-347LH
7 Type*:	EN ISO 17633-A - T 19 9 Nb P C1/M21 2
11 Diameter range:	1,2 - 1,6 mm
12 Auxiliary materials:	EN ISO 14175 - M2, M3, C

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 (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:
Zu Zeile 21: Die Eignung zur Wurzelschweißung auf keramische Badsicherung wurde nachgewiesen. Die Wurzelschweißbarkeit wurde nur auf Keramikunterlage nachgewiesen.

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	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