

TÜV-Verband Welding Consumable Leaflet

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

		1 Manufacturer/Supplier Kobelco Welding of Europe B.V. with manufacturer's works according to TÜV-Verband list 1000			2 Number: 12480.03 03.06.2026	
3 Welding consumable*:		Fülldrahtelektrode				
4 Trade name*:		DW-A55ESR				
7 Type*:		EN ISO 17632-A - T 42 4 P M21 1 H5				
11 Diameter range:		1,2 mm				
12 Auxiliary materials:		EN ISO 14175 - M21				
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	
	S	Gruppe 1.2				
	U	Gruppe 1.2				
	U	Gruppe 1.3 (ReH max. 420 MPa)				
	S	Gruppe 1.3 (ReH max. 420 MPa)				
	U	Gruppe 2.1				
	U	Gruppe 3.1 (ReH max. 420 MPa)				
	S	Gruppe 3.1 (ReH max. 420 MPa)				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		verified				
23 Wall thickness:		max. 50 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:		U; S: 350 °C				
27 Highest operating temperature in the long-term range max.:		--- °C				
28 Lowest operating temperature/as for parent metal, but not lower than:		U; S: -40 °C				
29 Design stress value/as for parent metal:		wie Grundwerkstoff im Kurzzeitbereich				
30 For use in the long-term range:		---				
31 Resistance to intergranular corrosion proven in accordance with:		---				
32 Remarks: Im reinen Schweißgut wurde der Gehalt an diffusiblem Wasserstoff mit HD ≤ 5cm ³ /100g nachgewiesen. Zu Zeile 21 Wurzelschweißbarkeit: 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 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