


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: 11727.03 17.03.2023	
		3 Welding consumable*: Fülldrahtelektrode				
4 Trade name*: DW-A55E						
7 Type*: EN ISO 17632-A T 46 4 P M 1 H5						
11 Diameter range: 1,2 bis 1,6 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	
	N	C 22.3				
	N	C 22.8				
	N	GP240GH				
	U	Gruppe 1.1				
	N	Gruppe 1.1				
	U	Gruppe 1.2				
	S	Gruppe 1.2				
	S	Gruppe 1.3 (ReH max. 420 MPa)				
	U	Gruppe 1.3 (ReH max. 460 MPa)				
	U	Gruppe 2.1				
	S	Gruppe 3.1 (ReH max. 420 MPa)				
	U	Gruppe 3.1 (ReH max. 460 MPa)				
	N	L245NB				
	S	L450MB				
	U	L485MB				
	N	P265GH				
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: N: 350; U,S; 450 °C						
27 Highest operating temperature in the long-term range max.: --- °C						
28 Lowest operating temperature/as for parent metal, but not lower than: N: -20; 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 <=5cm³/100g nachgewiesen						

*) Statements of the manufacturer

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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
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35 Compiled in accordance with the data of: TÜV Rheinland

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