

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: 12479.02 03.06.2026	
3 Welding consumable*: Fülldrahtelektrode						
4 Trade name*: DW-A81Ni1						
7 Type*: EN ISO 17632-A - T 46 6 1 Ni P M21 2 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	
	U	Gruppe 1.2				
	U	Gruppe 1.3 (ReH max. 460 MPa)				
	U	Gruppe 2.2				
	U	Gruppe 3.1 (ReH max. 460 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: 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: -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: - - -						
32 Remarks: Im reinen Schweißgut wurde der Gehalt an diffusen 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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