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: 10768.02 03.06.2026

3 Welding consumable*:	Fülldrahtelektrode
4 Trade name*:	MX -100T
7 Type*:	EN ISO 17632-A - T 42 2 M C1/M21 1 H5
11 Diameter range:	1,2 - 1,4 mm
12 Auxiliary materials:	EN ISO 14175 - M 21, M 3, C1

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
B	S	Gruppe 1.1			
A	U	Gruppe 1.2			
B	S	Gruppe 1.2 (ReH max. 290 MPa)			
A	U	Gruppe 1.3 (ReH max. 420 MPa)			
A	U	Gruppe 2.1 (ReH max. 420 MPa)			
A	U	Gruppe 3.1 (ReH max. 420 MPa)			
C	S	L290NB			

16 Material groups acc. to CR ISO 15608

21 Root weldability:	verified
23 Wall thickness:	max. 50mm
24 Type of current and polarity:	G+
25 Welding position according to DIN EN ISO 6947:1997-05:	PA, PB, PC, PE, PF
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:	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:	- 20 °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:

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

*) Statements of the manufacturer