

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: 10767.05 03.06.2026	
3 Welding consumable*:		Fülldrahtelektrode				
4 Trade name*:		MX-A100				
7 Type*:		EN ISO 17632-A T 42 4 M M21 3 H5				
11 Diameter range:		1,0 bis 2,0 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				
	N	Gruppe 1.1				
	S	Gruppe 1.1				
	U	Gruppe 1.2				
	U	Gruppe 1.3 (ReH max. 420 MPa)				
	U	Gruppe 2.1 (ReH max. 420 MPa)				
	U	Gruppe 3.1 (ReH max. 420 MPa)				
	U	L415MB				
	U	L415NB				
	N	L415NB				
	N	P265GH				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		not verified				
23 Wall thickness:		max. 80 mm				
24 Type of current and polarity:		G+				
25 Welding position according to DIN EN ISO 6947:1997-05: PA, PB, PC						
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:						- 40 (1) °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: (1) Kerbschlagarbeit im Wärmebehandlungszustand S und N bis -20°C nachgewiesen. Im reinen Schweißgut wurde der Gehalt an diffusiblem Wasserstoff mit HD ≤ 5 cm ³ /100 g 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

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