VdTÜV-Kennblatt for welding consumables

	1 Manufacturer/Supplier Kobelco Welding of Europe B.V. with manufacturer's works according to VdTÜV list 1000	2 No. of VdTÜV-Kennblatt: 07368.08 05.2009

3 Welding consumable*:	Fülldrahtelektrode
4 Trade name*:	DW-309MoL
7 Type*:	EN ISO 17633-A T 23 12 2 L R C/M 3
11 Diameter range:	1,2 bis 1,6 mm
12 Auxiliary materials:	EN ISO 14175 - M21, C1

13 The validity of this Kennblatt will be certified,respectively, in the latest edition of CD-ROM TÜV-eignungsgeprüfte Schweißzusätze

15 Materials and postweld heat treatment

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1. U: X 10 CrNiMoNb 18 12 (1.4583)
     verschweißt mit:
     P195GH , P265GH , P295GH , P355N

2. U: X 2 CrNiMoN 22 5 3 (1.4462) n. VdTÜV-Werkstoffblatt 418
     verschweißt mit:
     P195GH , P265GH , P295GH , P355N

3. Schweißplattierungen
 U:  Für die erste Lage von korrosionsbeständigen Schweißplattierungen an:
     P195GH , P265GH , P295GH , P355N
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16 Material groups acc. to CR ISO 15608

21 Root weldability:	not verified
23 Wall thickness:	maximal 30 mm (1)
24 Type of current and polarity:	G+
25 Welding position according to DIN ISO 6947:	PA, PB, PC, PF
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:	(2) 300°C
27 Highest operating temperature in the long-term range max.:	---°C
28 Lowest operating temperature/as for parent metal, but not lower than:	-10°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:

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(1) Unbegrenzt für die Trägerwerkstoffe bei Schweißplattierungen, soweit keine
Wärmebehandlung für die Grundwerkstoffe erforderlich wird.
(2) Für Schweißverbindungen mit 1.4462 maximal 250°C.

Zu Wurzelschweißbarkeit: Nur mit keramischer Schweißbadsicherung nachgewießen.
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33 The approval test was done on the basis of VdTÜV-Merkblatt 1153.Where nothing different is said under the heading -Remarks-, this welding consumable is suitable provided Annex I Point 4 of the Pressure Equipment Directive 97/23/EC is observed.

34 Explanations				
	A tempered	S stress-relieved	W soft annealed	G+ direct current plus pole
	L solution annealed and quenched	St stabilized		G- direct current minus pole
	N normalized	U non-annealed		W alternating current
		V hardened and tempered		

35 Compiled in accordance with the data of: TÜV Rheinland

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*) Statements of the manufacturer

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