

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: 07368.09 03.06.2026					
3 Welding consumable*: Fülldrahtelektrode								
4 Trade name*: DW-309MoL								
7 Type*: EN ISO 17633-A T 23 12 2 L R C1/M21 3								
11 Diameter range: 1,2 bis 1,6 mm								
12 Auxiliary materials: EN ISO 14175 - M21, 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								
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								
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 EN ISO 6947:1997-05: 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: (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 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.								
<table border="0"> <tr> <td>34 Explanations</td> <td>A tempered L solution annealed and quenched N normalized</td> <td>S stress-relieved St stabilized U non-annealed V hardened and tempered</td> <td>W soft annealed</td> <td>G+ direct current plus pole G- direct current minus pole W alternating current</td> </tr> </table>				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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