

VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier VDM Metals GmbH Plettenberger Straße 2 DEU 58791 Werdohl			2 No. of VdTÜV-Kennblatt: 18953.00 15.04.2016	
3 Welding consumable*:		Drahtelektrode				
4 Trade name*:		VDM ® FM 2120				
7 Type*:		EN ISO 18274 - S NiCr21Mo20				
11 Diameter range:		0,6 - 1,6 mm				
12 Auxiliary materials:		ISO 14175 -Z ArHeHC-30-2-0,05, -Z ArHeHC-30-2-0,12				
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						
Pos	Wb	Group / Material 1	Text	Group / Material 2	Remarks	
	U	Gruppe 43				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		verified				
23 Wall thickness:		max. 32 mm				
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:		550°C				
27 Highest operating temperature in the long-term range max.:		- - - °C				
28 Lowest operating temperature/as for parent metal, but not lower than:		-196°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:		EN ISO 3651-2				
32 Remarks:						
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 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 NORD				
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Dieses Kennblatt wurde mit Genehmigung des Herausgebers kostenlos durch die VDM Metals GmbH, 58762 Altena im Jahr 2021 zur Verfügung gestellt.

*) Statements of the manufacturer

VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier VDM Metals GmbH Plettenberger Straße 2 DEU 58791 Werdohl			2 No. of VdTÜV-Kennblatt: 18954.00 15.04.2016	
3 Welding consumable*:		Schweißstab und Schweißdraht				
4 Trade name*:		VDM ® FM 2120				
7 Type*:		EN ISO 18274 - S NiCr21Mo20				
11 Diameter range:		1,0 - 4,0 mm				
12 Auxiliary materials:		EN ISO 14175 - I1				
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						
Pos	Wb	Group / Material 1	Text	Group / Material 2	Remarks	
	U	Gruppe 43				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		verified				
23 Wall thickness:		max. 32 mm				
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:		550°C				
27 Highest operating temperature in the long-term range max.:		- - - °C				
28 Lowest operating temperature/as for parent metal, but not lower than:		- 196°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:		EN ISO 3651-2				
32 Remarks:						
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.						
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VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier VDM Metals GmbH Plettenberger Straße 2 DEU 58791 Werdohl			2 No. of VdTÜV-Kennblatt: 18965.00 10.05.2016	
		3 Welding consumable*: Drahtelektrode				
4 Trade name*: VDM ® FM 2120						
7 Type*: EN ISO 18274 - S NiCr21Mo20						
11 Diameter range: 0,6 - 1,6 mm						
12 Auxiliary materials: ISO 14175 - I1						
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						
Pos	Wb	Group / Material 1	Text	Group / Material 2	Remarks	
	U	Gruppe 43				
16 Material groups acc. to CR ISO 15608						
21 Root weldability: verified						
23 Wall thickness: max. 32 mm						
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: 550°C						
27 Highest operating temperature in the long-term range max.: - - - °C						
28 Lowest operating temperature/as for parent metal, but not lower than: -196°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: EN ISO 3651-2						
32 Remarks:						
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.						
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