



VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier VDM Metals GmbH Plettenberger Straße 2 DEU 58791 Werdohl		2 No. of VdTÜV-Kennblatt: 11245.02 12.10.2016	
3 Welding consumable*:		Drahtelektrode			
4 Trade name*:		VDM® FM 622			
7 Type*:		EN ISO 18274 - S Ni 6022 (NiCr21MoFe4W3)			
11 Diameter range:		1,0 bis 1,2 mm			
12 Auxiliary materials:		siehe Bemerkungsfeld 32			
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	NiCr21Mo14W			
	U	NiMo16Cr16Ti	verschweißt mit	NiMo16Cr15W	
16 Material groups acc. to CR ISO 15608					
21 Root weldability:		not verified			
23 Wall thickness:		maximal 35 mm			
24 Type of current and polarity:		G+			
25 Welding position according to DIN EN ISO 6947:1997-05: PA, PC, PF					
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:				500 °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:			- - -		
32 Remarks:					
Schutzgas : EN ISO 14175 - Z - ArHeHC - 30/2/0,05, Markenname "Cronigon Ni10"					
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 - Region Essen					
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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: 11246.01 08.2014	
3 Welding consumable*:		Schweißstab und Schweißdraht				
4 Trade name*:		VDM® FM 622				
7 Type*:		EN ISO 18274 - S Ni 6022 (NiCr21MoFe4W3)				
11 Diameter range:		0,8 bis 3,2 mm				
12 Auxiliary materials:		EN ISO 14175 - I1, R1 (Ar + max 3% H2)				
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	NiCr21Mo14W				
	U	NiMo16Cr15W				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		verified				
23 Wall thickness:		maximal 35 mm				
24 Type of current and polarity:		G-				
25 Welding position according to DIN ISO 6947:		PA, PC, PF				
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:		500 °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:		- - -				
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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