

TÜV-Verband Welding Consumable Leaflet

according to TÜV-Verband Technical Leaflet 1153 and DIN EN 14532

		1 Manufacturer/Supplier VDM Metals GmbH Plettenberger Straße 2 DEU 58791 Werdohl			2 Number: 19891.00 02.08.2023	
		3 Welding consumable*: Schweißstab und Schweißdraht				
4 Trade name*: VDM FM 699 XA						
7 Type*: ISO 18274 – S Ni 6699 (NiCr29Al)						
11 Diameter range: 1,0 - 4,0 mm						
12 Auxiliary materials: EN ISO 14175: I1						
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	
	U	Gruppe 43				
16 Material groups acc. to CR ISO 15608						
21 Root weldability: verified						
23 Wall thickness: 32 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: 550 °C						
27 Highest operating temperature in the long-term range max.: siehe Bemerkungen Zeile 32 / see remarks in row 32 -- °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 / as base metal						
30 For use in the long-term range: For creep rupture, see remarks						
31 Resistance to intergranular corrosion proven in accordance with:						
32 Remarks: Creep rupture tests on all-weld metal according to TÜV-Verband Technical Leaflet 1153 / DIN EN 14532-2:2004, Clause 4.2.3.4, are currently being carried out. The welding consumable manufacturer shall be consulted regarding the status of creep rupture testing carried out on all-weld material and, if available, on welded joints, and regarding the resulting characteristic values for the calculation of permissible stresses.						
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 NORD						
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*) Statements of the manufacturer