


# VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier VDM Metals GmbH Plettenberger Straße 2 DEU 58791 Werdohl			2 No. of VdTÜV-Kennblatt: 07736.03 08.2014	
3 Welding consumable*:		Drahtelektrode				
4 Trade name*:		VDM® FM B-2				
7 Type*:		EN ISO 18274 - S Ni 1066 (NiMo28)				
11 Diameter range:		0,8 bis 1,2 mm				
12 Auxiliary materials:		EN ISO 14175 - I 1, Cronigon Ni 20				
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	NiMo28				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		not verified				
23 Wall thickness:		maximal 20 mm				
24 Type of current and polarity:		G+				
25 Welding position according to DIN ISO 6947:		PA, PB				
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:		400 °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:		SEP 1877 Verfahren III				
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	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 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: 07737.03 08.2014	
3 Welding consumable*:		Schweißstab und Schweißdraht				
4 Trade name*:		VDM® FM B-2				
7 Type*:		EN ISO 18274 - S Ni 1066 (NiMo28)				
11 Diameter range:		1,2 bis 3,2 mm				
12 Auxiliary materials:		EN ISO 14175 - I 1, R 1 (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	
	L	NiMo28				
	U	NiMo28				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		verified				
23 Wall thickness:		max. 40 mm, Wurzel: unbegrenzt				
24 Type of current and polarity:		G-				
25 Welding position according to DIN ISO 6947:		PA, PB, PF				
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:		400 °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:		SEP 1877 Verfahren III				
32 Remarks: Prägung der Schweißstäbe: 2.4615 B.						
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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