


VdTÜV-Kennblatt for welding consumables

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|---|----|---|-------------------------|--------------------|---|--|
|  | | 1 Manufacturer/Supplier VDM Metals GmbH Plettenberger Straße 2 DEU 58791 Werdohl | | | 2 No. of VdTÜV-Kennblatt: 11451.02 08.2014 | |
| 3 Welding consumable*: | | Schweißstab und Schweißdraht | | | | |
| 4 Trade name*: | | VDM ® FM C-263 | | | | |
| 7 Type*: | | EN ISO 18274 - S NiCr20Co20Mo6Ti2 | | | | |
| 11 Diameter range: | | 1,0 - 3,0 (1) mm | | | | |
| 12 Auxiliary materials: | | EN ISO 14175 I 1 | | | | |
| 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 46 | | | (2) | |
| 16 Material groups acc. to CR ISO 15608 | | | | | | |
| 21 Root weldability: | | verified | | | | |
| 23 Wall thickness: | | max. 10 / 30 mm (3) | | | | |
| 24 Type of current and polarity: | | G- | | | | |
| 25 Welding position according to DIN ISO 6947: | | PA, PB, PC | | | | |
| 26 Highest operating temperature in the short-term range as for parent metal, but not higher than: | | 750 (4) °C | | | | |
| 27 Highest operating temperature in the long-term range max.: | | (5) °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: | | (5) | | | | |
| 31 Resistance to intergranular corrosion proven in accordance with: | | --- | | | | |
| 32 Remarks: (1) Draht: 1,0 – 1,2 mm, Stab: 1,6 – 3,0 mm (2) Wärmebehandlung: ausgehärtet bei 800 °C / 4 h (3) Dicke: max. 10 mm: Stab, max. 30 mm: Draht (4) Die Versprödungsprüfung gemäß EN 14532-2 Kap. 4.2.wurde nachgewiesen (5) Zeitstandwerte sind in Absprache mit der benannten Stelle beim Hersteller zu erfragen | | | | | | |
| 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 | | | | |
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*) Statements of the manufacturer