



VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier VDM Metals GmbH Plettenberger Straße 2 DEU 58791 Werdohl		2 No. of VdTÜV-Kennblatt: 04588.03 08.2014	
3 Welding consumable*:		Drahtelektrode			
4 Trade name*:		VDM® FM C-4			
7 Type*:		EN ISO 18274 - S Ni 6455 (NiCr16Mo16Ti)			
11 Diameter range:		0,8 bis 1,6 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	NiMo16Cr16Ti			
16 Material groups acc. to CR ISO 15608					
21 Root weldability:		not verified			
23 Wall thickness:		maximal 30 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:		(1)			
32 Remarks: (1) Modifizierter Streichertest, Verfahren II nach SEP 1877.					
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: 04589.04 08.2014
3 Welding consumable*: Schweißstab und Schweißdraht		
4 Trade name*: VDM® FM C-4		
7 Type*: EN ISO 18274 - S Ni 6455 (NiCr16Mo16Ti)		
11 Diameter range: 1,0 bis 4,0 mm		
12 Auxiliary materials: ENISO 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		
NiMo 16 Cr 16 Ti (2.4610) VdTÜV-Werkstoffblatt 424 Wärmebehandlung: U Mischverbindungen zwischen NiMo 16 Cr 16 Ti (2.4610) und P235 GH, P265 GH, S355 NH, 17 Mn 4 Wärmebehandlung: U		
16 Material groups acc. to CR ISO 15608		
21 Root weldability: verified		
23 Wall thickness: maximal 12 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: 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: (1)		
32 Remarks: (1) Modifizierter Streichertest, Verfahren II nach SEP 1877. Prägung der Schweißstäbe: 2.4611-B/ERNiCrMo7.		
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
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