



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: 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. | | | | | |
| 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 2020 zur Verfügung gestellt.

*) Statements of the manufacturer

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|--|----|---|---|-------------------------|--|--|
|  | | 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 | |
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