



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 <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">A tempered</td> <td style="width: 25%;">S stress-relieved</td> <td style="width: 25%;">W soft annealed</td> <td style="width: 25%;">G+ direct current plus pole</td> </tr> <tr> <td>L solution annealed and quenched</td> <td>St stabilized</td> <td></td> <td>G- direct current minus pole</td> </tr> <tr> <td>N normalized</td> <td>U non-annealed</td> <td></td> <td>W alternating current</td> </tr> <tr> <td></td> <td>V hardened and tempered</td> <td></td> <td></td> </tr> </table>			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		
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35 Compiled in accordance with the data of: TÜV NORD - Region Essen																		
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*) 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: 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	
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