


VdTÜV-Kennblatt for welding consumables

	1 Manufacturer/Supplier VDM Metals GmbH Plettenberger Straße 2 DEU 58791 Werdohl	2 No. of VdTÜV-Kennblatt: 11218.01 08.2014																
3 Welding consumable*: Schweißdraht																		
4 Trade name*: VDM® FM 36 LT																		
7 Type*: EN ISO 14343-A - WZ Ni 36																		
11 Diameter range: 1,2 mm																		
12 Auxiliary materials: EN ISO 14175 - R 1 (Ar + max 5% 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																		
<p>Ni 36 nach SEW 385 (1)</p> <p>Wärmebehandlung: U</p> <p>An die mit dem Plasma-Prozess hergestellten Verbindungsschweißungen wurden folgende, vom Grundwerkstoff abweichende Anforderungen bei der Eignungsprüfung zu Grunde gelegt: Rm > 410 MPa, A5 > 25%.</p>																		
16 Material groups acc. to CR ISO 15608																		
21 Root weldability: verified																		
23 Wall thickness: max. 32 mm																		
24 Type of current and polarity: G-																		
25 Welding position according to DIN ISO 6947: PA, PC																		
26 Highest operating temperature in the short-term range as for parent metal, but not higher than: 200°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: (1) Der Grundwerkstoff ist für den Einsatz nach Druckgeräterichtlinie nicht eignungsgeprüft.																		
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 border="0" style="width: 100%; border-collapse: collapse;"> <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