

VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier Lincoln Electric Europe B.V. - SAF-FR0-Brand with manufacturer's works according to VdTÜV list 1000		2 No. of VdTÜV-Kennblatt: 04120.09 21.06.2018	
3 Welding consumable*:		Drahtelektrode			
4 Trade name*:		FILCORD D			
7 Type*:		EN ISO 14341-A - G 46 4 M 4Si1 / G 46 3 C 4Si1			
11 Diameter range:		0,8 bis 2,0 mm			
12 Auxiliary materials:		EN ISO 14175 - M2 - M3 - C1			
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
	N	Gruppe 1.1			
	U	Gruppe 1.1			
	S	Gruppe 1.1			
	U	Gruppe 1.2			
	S	Gruppe 1.2			
	N	Gruppe 1.2 (ReH max. 290 MPa)			
	S	Gruppe 1.3 (ReH max. 420 MPa)			(1)
	U	Gruppe 1.3 (ReH max. 460 MPa)			
	U	Gruppe 2.1			
	S	Gruppe 2.1 (ReH max. 420 MPa)			(1)
	S	Gruppe 3.1 (ReH max. 420 MPa)			(1)
	U	Gruppe 3.1 (ReH max. 460 MPa)			
16 Material groups acc. to CR ISO 15608					
21 Root weldability:		verified			
23 Wall thickness:		max. 50 mm			
24 Type of current and polarity:		G+			
25 Welding position according to DIN EN ISO 6947:1997-05: PA, PB, PC, PD, PE, PF, PG					
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:				450°C	
27 Highest operating temperature in the long-term range max.:				- - - °C	
28 Lowest operating temperature/as for parent metal, but not lower than:				(2) , (3) -40°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) Gilt nur für M2; S: Temperatur 580°C, Haltezeit 1 h. (2) M2 - M3: tmin = -50°C für Glühzustand U und S; M2 - C: tmin = -10°C für Glühzustand N.					
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 Pfalz			
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*) Statements of the manufacturer

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