


VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier MIGAL.CO GmbH Wattstraße 2 DEU 94405 Landau / Isar			2 No. of VdTÜV-Kennblatt: 11870.01 13.10.2017	
3 Welding consumable*:		Drahtelektrode				
4 Trade name*:		ML 19.9 LSi				
7 Type*:		EN ISO 14343-A - G 19 9 L Si				
11 Diameter range:		0,6 bis 1,6 mm				
12 Auxiliary materials:		EN ISO 14175 - M12				
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	Gruppe 8.1 (ohne Mo)				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		verified				
23 Wall thickness:		maximal 30 mm				
24 Type of current and polarity:		G+				
25 Welding position according to DIN EN ISO 6947:1997-05: PA, PB, PF						
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:					350 °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:			DIN 50914			
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	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			
35 Compiled in accordance with the data of:				TÜV Rheinland		
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*) Statements of the manufacturer