


VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier MIGAL.CO GmbH Wattstraße 2 DEU 94405 Landau / Isar			2 No. of VdTÜV-Kennblatt: 12151.02 28.06.2019	
		3 Welding consumable*: Schweißstab und Schweißdraht				
4 Trade name*: ML 22.9.3 NL (SS/SD)						
7 Type*: EN ISO 14343-A - W 22 9 3 NL						
11 Diameter range: 0,6 bis 4,0 mm						
12 Auxiliary materials: EN ISO 14175 - I1						
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 10.1 (X2CrNiMoN225)				
	U	Gruppe 8.1	verschweißt mit	Gruppe 1.2		
16 Material groups acc. to CR ISO 15608						
21 Root weldability: verified						
23 Wall thickness: maximal 20 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						
26 Highest operating temperature in the short-term range as for parent metal, but not higher than: 250°C						
27 Highest operating temperature in the long-term range max.: - - - °C						
28 Lowest operating temperature/as for parent metal, but not lower than: -60°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, CPT-Test nach ASTM G 48, 22°C/72 h						
32 Remarks: Schweißstabprägung: SM ARC 45 N (Farbbeschriftung).						
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 Rheinland						
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*) Statements of the manufacturer