


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