


VdTÜV-Kennblatt for welding consumables

	1 Manufacturer/Supplier MIGAL.CO GmbH Wattstraße 2 DEU 94405 Landau / Isar	2 No. of VdTÜV-Kennblatt: 12478.02 13.10.2017																
3 Welding consumable*: Drahtelektrode																		
4 Trade name*: ML NiCr 21 Mo 9 Nb (DE)																		
7 Type*: EN ISO 18274 -G S Ni 6625																		
11 Diameter range: 0,8 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																		
a) X 2 CrNiMoCuN 20 18 6 (AVESTA 254 SMO) nach VdTÜV-Werkstoffblatt 473 X 1 NiCrMoCuN 25 20 6 (1.4529) VdTÜV-Werkstoffblatt 502 X 1 NiCrMoCuN 25 20 5 (1.4539) VdTÜV-Werkstoffblatt 421 b) Gruppe 8.1 c) Gruppen 1.1 ; 1,2 ; 1.3 (bis ReH 420N/mm ²) U, L: 1. Werkstoffe der Position a) 2. Werkstoffe der Position a) mit b) U: 3. Werkstoffe der Position a) mit c) 4. Werkstoffe der Position a) mit c)																		
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, PC, PD, PE, PF																		
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: -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: Die Warmfestigkeit wurde im Kurzzeitbereich bis 550°C überprüft.																		
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 style="width: 100%; border: none;"> <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 Rheinland																		
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*) Statements of the manufacturer