


VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier "Multimet" Sp. z o. o. ul. Fabryczna 10 POL 59-170 Przemkow			2 No. of VdTÜV-Kennblatt: 12259.04 04.2015	
3 Welding consumable*:		Draht-Pulver-Kombination				
4 Trade name*:		IMT9				
6 Flux trade name*:		TAL 1700				
7 Type*:		EN ISO 14171-A - S2				
9 Flux type*:		EN ISO 14174 - SA AB 1 67 AC H5				
10 Flux grain size*:		2 - 20				
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 1.1				
	S	Gruppe 1.1				
	S	Gruppe 1.2				
	U	Gruppe 1.2				
16 Material groups acc. to CR ISO 15608						
19 The scope indicated in the data sheet has been specified taking into account the following welding parameters applied for all-weld metal used for the performance test. 19 If not stated otherwise in remarks, the approval test is valid for the flat position.						
20 Wire diameter		20 Amperage		20 Voltage		20 Travel speed
4,0		550 - 600		29		55
22 Electrode flux Build-up of seam suitability for: single-layer welds, multiple layer welds						
23 Wall thickness:		unbegrenzt				
24 Type of current and polarity:		G+, W				
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:						-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: ---						
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 SÜD Industrie Service GmbH, München		
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*) Statements of the manufacturer