


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: 12271.02 29.06.2015	
3 Welding consumable*:		Draht-Pulver-Kombination				
4 Trade name*:		IMT9 Ni2				
6 Flux trade name*:		TAL 3000				
7 Type*:		EN ISO 14171-A - S2Ni2				
9 Flux type*:		S A FB 1 55 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 3.1 (ReH max.460 MPa)			2)	
	S	Gruppe 2.1			2)	
	U	Gruppe 1.1				
	S	Gruppe 3.1 (ReH max.460 MPa)			2)	
	S	Gruppe 1.1				
	U	Gruppe 1.3 (ReH max.460 MPa)			2)	
	S	Gruppe 1.2				
	U	Gruppe 2.1			2)	
	S	Gruppe 1.3 (ReH max.460 MPa)			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	20 Working temperature		
4,0	610 - 630	29 - 30	44 - 49	max. 200 3)		
4,0	550 - 600	29	55	max. 175		
22 Electrode flux Build-up of seam suitability for:		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:				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:				1) 2) -70°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: 1) Im reinen Schweißgut / spannungsarm gegläht wurde die Kerbschlagarbeit > 47 J bis -80 °C nachgewiesen. 2) bis -77°C 3) bei der Eignungsprüfung für die Erweiterung auf die Gruppen 1.3, 2.1 und 3.1 angewendete Schweißparameter; Schweißung mit Stromart/Polung G+						

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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
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35 Compiled in accordance with the data of: TÜV SÜD Industrie Service GmbH, München

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