


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: 18845.00 14.12.2015	
3 Welding consumable*:		Fülldrahtelektrode			
4 Trade name*:		IMT R711			
7 Type*:		EN ISO 17632-A - T 46 4 P M 1 H5 / T 46 2 P C 1 H5			
11 Diameter range:		1,0 bis 1,6 mm			
12 Auxiliary materials:		Gase EN ISO 14175 - C1, M21-M35			
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			
	U	Gruppe 1.2			
	U	Gruppe 1.3 (ReH max. 460 MPa)			
	U	Gruppe 2.1			
	U	Gruppe 3.1 (ReH max. 460 MPa)			
16 Material groups acc. to CR ISO 15608					
21 Root weldability:		verified			
23 Wall thickness:		unbegrenzt			
24 Type of current and polarity:		G+			
25 Welding position according to DIN ISO 6947:		PA, PB, PC, PD, PE, PF, PG			
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 2) °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) Position PE nur mit Schutzgas M21 2) für Schutzgas C1 max. -20 °C Reh im reinen Schweißgut: > 460 Mpa					
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