


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: 18846.00 14.12.2015	
3 Welding consumable*:		Fülldrahtelektrode			
4 Trade name*:		IMT R811			
7 Type*:		EN ISO 17632-A - T 50 6 1Ni P M 1 H5 / T 46 5 1Ni P C 1 H5			
11 Diameter range:		1,2 bis 1,6 mm			
12 Auxiliary materials:		Gase EN 14175 - C1, M21-M33			
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			
	U	Gruppe 1.2			
	S	Gruppe 1.2			
	U	Gruppe 1.3 (ReH max. 500 MPa)			
	S	Gruppe 1.3 (ReH max. 500 MPa)			1)
	U	Gruppe 2.1			
	U	Gruppe 2.2 (ReH max. 500 MPa)			
	U	Gruppe 3.1 (ReH max. 500 MPa)			
	S	Gruppe 3.1 (ReH min. 500 MPa)			1)
16 Material groups acc. to CR ISO 15608					
21 Root weldability:		not 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			
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:		2) -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:		---			
32 Remarks:					
1) Wärmebehandlung S nur für Elektroden-Durchmesser 1,2 mm; mit Schutzgas M21: bis ReH max. 500 MPa, mit Schutzgas C1 bis M22: bis ReH max. 460 MPa 2) mit Schutzgas M21 bis -60 °C; mit Schutzgas C1 - M22 nur bis -50 °C					
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	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		
35 Compiled in accordance with the data of:		TÜV SÜD Industrie Service GmbH, München			
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*) Statements of the manufacturer