


VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier VDM Metals GmbH Plettenberger Straße 2 DEU 58791 Werdohl		2 No. of VdTÜV-Kennblatt: 11451.02 08.2014	
3 Welding consumable*:		Schweißstab und Schweißdraht			
4 Trade name*:		VDM ® FM C-263			
7 Type*:		EN ISO 18274 - S NiCr20Co20Mo6Ti2			
11 Diameter range:		1,0 - 3,0 (1) mm			
12 Auxiliary materials:		EN ISO 14175 I 1			
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 46			(2)
16 Material groups acc. to CR ISO 15608					
21 Root weldability:		verified			
23 Wall thickness:		max. 10 / 30 mm (3)			
24 Type of current and polarity:		G-			
25 Welding position according to DIN ISO 6947:		PA, PB, PC			
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:		750 (4) °C			
27 Highest operating temperature in the long-term range max.:		(5) °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:		(5)			
31 Resistance to intergranular corrosion proven in accordance with:		---			
32 Remarks: (1) Draht: 1,0 – 1,2 mm, Stab: 1,6 – 3,0 mm (2) Wärmebehandlung: ausgehärtet bei 800 °C / 4 h (3) Dicke: max. 10 mm: Stab, max. 30 mm: Draht (4) Die Versprödungsprüfung gemäß EN 14532-2 Kap. 4.2.wurde nachgewiesen (5) Zeitstandwerte sind in Absprache mit der benannten Stelle beim Hersteller zu erfragen					
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 NORD			
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*) Statements of the manufacturer