

TÜV-Verband Welding Consumable Leaflet
according to TÜV-Verband Technical Leaflet 1153 and DIN EN 14532

		1 Manufacturer/Supplier DAIKO S.R.L. Viale Felissent, 84/D ITA 31100 Treviso (TV)		2 Number: 19540.02 29.09.2025	
3 Welding consumable*:		Schweißstab			
4 Trade name*:		DAIKOWT 2209			
7 Type*:		EN ISO 14343-A - W 22 9 3 N L			
11 Diameter range:		1,0 bis 4,0 mm			
12 Auxiliary materials:		EN ISO 14175 - I1			
13 The validity is certified by the appearance of the welding consumable leaflet in the welding consumables portal.					
15 Materials and postweld heat treatment					
Pos	Wb	Group / Material 1	Text	Group / Material 2	Remarks
	U	Gruppe 10.1 (Duplex)	verschweißt mit	Gruppe 1.1	
	U	Gruppe 10.1 (Duplex)			
16 Material groups acc. to CR ISO 15608					
21 Root weldability:		not verified			
23 Wall thickness:		max. 40 mm			
24 Type of current and polarity:		G-			
25 Welding position according to DIN EN ISO 6947:1997-05:		PA, PC			
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:				250 °C	
27 Highest operating temperature in the long-term range max.:				- - - °C	
28 Lowest operating temperature/as for parent metal, but not lower than:				-80 °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:		EN ISO 3651-2			
32 Remarks:					
Prägung der Schweißstäbe: "V 2209"					
33 The approval test for the welding consumable was carried out on the basis of TÜV-Verband Technical Leaflet 1153 and DIN EN 14532. If no conflicting test principles are stated under heading 32 – Remarks –, this welding consumable is suitable for use according to the Pressure Equipment Directive 2014/68/EU, Annex I Point 4.					
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 NORD Gruppe			
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