

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: 19355.03-	
3 Welding consumable*:		Schweißstab und Schweißdraht				
4 Trade name*:		DAIKOWT 2594				
7 Type*:		EN ISO 14343-A - W 25 9 4 N L				
11 Diameter range:		1,0 - 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	X2CrNiMoCuWN25-7-4				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		verified				
23 Wall thickness:		max. 6 mm; Wurzelschweißung: unbegrenzt				
24 Type of current and polarity:		G-				
25 Welding position according to DIN EN ISO 6947:1997-05: PA, PC, PF						
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:						220 °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 °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 Verfahren C			
32 Remarks :						
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 Rheinland		
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