

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: 11862.04-
3 Welding consumable*: Drahtelektrode			
4 Trade name*: DAIKOWM 82			
7 Type*: Massivdraht EN ISO 18274-S Ni 60 82 (NiCr20Mn3Nb)			
11 Diameter range: 1,2 mm			
12 Auxiliary materials: EN ISO 14175 - I 1			
13 The validity is certified by the appearance of the welding consumable leaflet in the welding consumables portal.			
15 Materials and postweld heat treatment			
Auftragsschweißen auf Werkstoffen der Gruppen: U Gruppe 1.1 (ReH max.275 MPa) U Gruppe 72.2 (Rpo2 max. 250 MPa)			
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 EN ISO 6947:1997-05: PA			
26 Highest operating temperature in the short-term range as for parent metal, but not higher than: ---- °C			
27 Highest operating temperature in the long-term range max.: ---- °C			
28 Lowest operating temperature/as for parent metal, but not lower than: Rt °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: Der Einsatz des Schweißzusatzwerkstoffes ist nur für Auftragsschweißungen nachgewiesen.			
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			
The duplication, circulation, copy and complete edition by photomechanical or similar techniques remain subject to the editor's approval even if only used in extracts. Editor: TÜV-Verband e. V. Distribution: TÜV-Media GmbH, Am Grauen Stein, 51105 Köln - Unternehmensgruppe TÜV Rheinland Group			