

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: 19445.01-
3 Welding consumable*: Fülldrahtelektrode			
4 Trade name*: DAIK0FCW 316L			
7 Type*: EN ISO 17633-A T 19 12 3 L R C1/M21 3			
11 Diameter range: 0,9 bis 1,6 mm			
12 Auxiliary materials: EN ISO 14175 - M21, C1			
13 The validity is certified by the appearance of the welding consumable leaflet in the welding consumables portal.			
15 Materials and postweld heat treatment			
1. Schweißverbindungen U, L: Gruppe 8.1 mit Mo ohne N Gruppe 8.1 ohne Mo ohne N 2. Schweißplattierungen U: Für die zweite und weitere Lagen von korrosionsbeständigen Schweißplattierungen auf den Werkstoffen P195GH , P265GH , P295GH , P355N , 16 Mo 3			
16 Material groups acc. to CR ISO 15608			
21 Root weldability: not verified			
23 Wall thickness: maximal 30 mm (1)			
24 Type of current and polarity: G+			
25 Welding position according to DIN EN ISO 6947:1997-05: PA, PB, PC, PF			
26 Highest operating temperature in the short-term range as for parent metal, but not higher than: (2) 400 °C			
27 Highest operating temperature in the long-term range max.: - - - °C			
28 Lowest operating temperature/as for parent metal, but not lower than: -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: DIN 50914			
32 Remarks: (1) Für den Trägerwerkstoff bei Plattierungen maximal 50 mm. (2) Für Mischverbindungen maximal 300°C. *Wurzelschweißbarkeit wurde auf keramischer Badsicherung 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			
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