

# TÜV-Verband Welding Consumable Leaflet

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

|                                                                                                                                                                                                                                                                                                                                        |    |                                                                                            |                                                                                 |                    |                                                                                      |         |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----|--------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------|--------------------|--------------------------------------------------------------------------------------|---------|
|                                                                                                                                                                                                                                                       |    | 1 Manufacturer/Supplier<br>DAIKO S.R.L.<br>Viale Felissent, 84/D<br>ITA 31100 Treviso (TV) |                                                                                 |                    | 2 Number:<br>19448.01-                                                               |         |
| 3 Welding consumable*:                                                                                                                                                                                                                                                                                                                 |    | Fülldrahtelektrode                                                                         |                                                                                 |                    |                                                                                      |         |
| 4 Trade name*:                                                                                                                                                                                                                                                                                                                         |    | DAIKOFCW 347P                                                                              |                                                                                 |                    |                                                                                      |         |
| 7 Type*:                                                                                                                                                                                                                                                                                                                               |    | EN ISO 17633-A - T 19 9 Nb P M,C                                                           |                                                                                 |                    |                                                                                      |         |
| 11 Diameter range:                                                                                                                                                                                                                                                                                                                     |    | 1,2 - 1,6 mm                                                                               |                                                                                 |                    |                                                                                      |         |
| 12 Auxiliary materials:                                                                                                                                                                                                                                                                                                                |    | EN ISO 14175 - M2, M3, C                                                                   |                                                                                 |                    |                                                                                      |         |
| 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 8.1 (ohne Mo)                                                                       |                                                                                 |                    |                                                                                      |         |
| 16 Material groups acc. to CR ISO 15608                                                                                                                                                                                                                                                                                                |    |                                                                                            |                                                                                 |                    |                                                                                      |         |
| 21 Root weldability:                                                                                                                                                                                                                                                                                                                   |    | verified                                                                                   |                                                                                 |                    |                                                                                      |         |
| 23 Wall thickness:                                                                                                                                                                                                                                                                                                                     |    | max. 30 mm                                                                                 |                                                                                 |                    |                                                                                      |         |
| 24 Type of current and polarity:                                                                                                                                                                                                                                                                                                       |    | G+                                                                                         |                                                                                 |                    |                                                                                      |         |
| 25 Welding position according to DIN EN ISO 6947:1997-05: PA, PB, PC, PD, PE, PF                                                                                                                                                                                                                                                       |    |                                                                                            |                                                                                 |                    |                                                                                      |         |
| 26 Highest operating temperature in the short-term range as for parent metal, but not higher than:                                                                                                                                                                                                                                     |    |                                                                                            |                                                                                 |                    |                                                                                      | 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:                                                                                                                                                                                                                                                               |    |                                                                                            |                                                                                 |                    |                                                                                      | -196 °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:<br>Zu Zeile 21: Die Eignung zur Wurzelschweißung auf keramische Badsicherung wurde nachgewiesen. Die Wurzelschweißbarkeit wurde nur auf Keramikunterlage 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<br>L solution annealed and quenched<br>N normalized                             | S stress-relieved<br>St stabilized<br>U non-annealed<br>V hardened and tempered | W soft annealed    | G+ direct current plus pole<br>G- direct current minus pole<br>W alternating current |         |
| 35 Compiled in accordance with the data of:                                                                                                                                                                                                                                                                                            |    |                                                                                            |                                                                                 | TÜV Rheinland      |                                                                                      |         |
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