

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: 11868.05-	
3 Welding consumable*:		Schweißstab und Schweißdraht			
4 Trade name*:		DAIKOWT 625			
7 Type*:		EN ISO 18274 - W S Ni 6625			
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					
a) X 2 CrNiMoCuN 20 18 6 (AVESTA 254 SMO) nach VdTÜV-Werkstoffblatt 473 X 1 NiCrMoCuN 25 20 6 (1.4529) VdTÜV-Werkstoffblatt 502 X 1 NiCrMoCuN 25 20 5 (1.4539) VdTÜV-Werkstoffblatt 421 b) Gruppe 8.1 c) Gruppen 1.1 ; 1.2 ; 1.3 (max. ReH 420 N/mm2) U, L: 1. Werkstoffe der Position a) 2. Werkstoffe der Position a) mit b) U: 3. Werkstoffe der Position a) mit c) 4. Werkstoffe der Position a) mit c)					
16 Material groups acc. to CR ISO 15608					
21 Root weldability:		verified			
23 Wall thickness:		maximal 20 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:		450 °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:		DIN 50914			
32 Remarks: Die Warmfestigkeit wurde im Kurzzeitbereich bis 550°C überprüft. Schweißstabprägung: ER NiCrMo-3 Die Warmfestigkeit wurde im Kurzzeitbereich bis 550°C überprüft. Schweißstabprägung: PHYWELD 625.					
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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