TÜV-Verband Welding Consumable Leaflet

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

TÜV VERBAND	1 Manufacturer/Supplier DAIKO S.R.L. Viale Felissent, 84/D ITA 31100 Treviso (TV)	2 Number: 11860.02-

3 Welding consumable*:	Drahtelektrode
4 Trade name*:	DAIKOWM 318Si
7 Type*:	EN ISO 14343-A - G 19 12 3 Nb
11 Diameter range:	0,8 bis 1,6 mm
12 Auxiliary materials:	EN ISO 14175 - M12,M13

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			

16 Material groups acc. to CR ISO 15608

21 Root weldability:	verified
23 Wall thickness:	maximal 30 mm
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:	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:	DIN 50914

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	S stress-relieved	W soft annealed	G+ direct current plus pole
	L solution annealed and quenched	St stabilized		G- direct current minus pole
	N normalized	U non-annealed		W alternating current
		V hardened and tempered		

35 Compiled in accordance with the data of: TÜV Rheinland

*) Statements of the manufacturer