


VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier ASKAYNAK TUR Istanbul		2 No. of VdTÜV-Kennblatt: 12670.00 11.2013	
3 Welding consumable*:		Drahtelektrode			
4 Trade name*:		AS SG2 PERFORMANCE			
7 Type*:		EN ISO 14341-A - G 42 3 C1 / G 42 5 M21/M32 3Si1			
11 Diameter range:		0,8 bis 1,6 mm			
12 Auxiliary materials:		EN ISO 14175 - C, M20 bis M26, M3			
13 The validity of this Kennblatt will be certified, respectively, in the latest edition of CD-ROM TÜV-eignungsgeprüfte Schweißzusätze					
15 Materials and postweld heat treatment					
Pos	Wb	Group / Material 1	Text	Group / Material 2	Remarks
	U	Gruppe 1.1			
	U	Gruppe 1.2			
16 Material groups acc. to CR ISO 15608					
21 Root weldability:		verified			
23 Wall thickness:		maximal 50 mm			
24 Type of current and polarity:		G+			
25 Welding position according to DIN EN ISO 6947:1997-05: PA, PB, PC, PE, PF, PG					
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:					1) °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: 1) C: -30 °C, M20 - M26 und M3: -50					
33 The approval test was done on the basis of VdTÜV-Merkblatt 1153. Where nothing different is said under the heading -Remarks-, this welding consumable is suitable provided Annex I Point 4 of the Pressure Equipment Directive 97/23/EC is observed.					
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 NORD	
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: Verband der TÜV e. V. Distribution: TÜV-Media GmbH, Am Grauen Stein, 51105 Köln - Unternehmensgruppe TÜV Rheinland Group					