


VdTÜV-Kennblatt for welding consumables

| | | | | | |
|--|----|--|---|---|--|
|  | | 1 Manufacturer/Supplier ASKAYNAK TUR Istanbul | | 2 No. of VdTÜV-Kennblatt: 12334.02 02.2014 | |
| 3 Welding consumable*: | | Stabelektrode | | | |
| 4 Trade name*: | | AS P - 309L Super | | | |
| 7 Type*: | | DIN EN 3581-A - E 23 12 3 LR 1 2 | | | |
| 11 Diameter range: | | 3,2 bis 4,0 mm | | | |
| 12 Auxiliary materials: | | --- | | | |
| 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 8.1 | | | |
| 16 Material groups acc. to CR ISO 15608 | | | | | |
| 21 Root weldability: | | not verified | | | |
| 23 Wall thickness: | | max. 30 m | | | |
| 24 Type of current and polarity: | | G+, W | | | |
| 25 Welding position according to DIN EN ISO 6947:1997-05: PA, PB, PC | | | | | |
| 26 Highest operating temperature in the short-term range as for parent metal, but not higher than: | | | | 350°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: | | --- | | | |
| 32 Remarks: --- | | | | | |
| 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 | | | | | |