


# VdTÜV-Kennblatt for welding consumables

|  |    |  |   |  |  |
|--|----|--|---|--|--|
|   |    | 1 Manufacturer/Supplier<br>ASKAYNAK<br>TUR Istanbul            |   | 2 No. of<br>VdTÜV-Kennblatt:<br>07464.09<br>23.04.2020 |  |
| 3 Welding consumable*:   |    | Drahtelektrode   |   |  |  |
| 4 Trade name*:   |    | AS SG2   |   |  |  |
| 7 Type*:   |    | EN ISO 14341-A - G 42 3 C / G 46 4 M 3Si1                      |   |  |  |
| 11 Diameter range:   |    | 0,8 bis 1,6 mm   |   |  |  |
| 12 Auxiliary materials:  |    | EN ISO 14175 - C, M2, 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   |   |  |  |
|  | U  | Gruppe 2.1 (ReH max. 460 MPa)                                  |   |  |  |
| 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:   |    |  |   |  | 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:   |    |  |   |  | 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:<br>1) C: -30°C, M2, M3: -40  |    |  |   |  |  |
| 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<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 NORD   |  |
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