


VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier ITW Welding GmbH DEU 67317 Altleiningen		2 No. of VdTÜV-Kennblatt: 09805.06 11.2013	
3 Welding consumable*:		Fülldrahtelektrode			
4 Trade name*:		MEGAFIL 240 M			
7 Type*:		EN ISO 17632- A - T 50 6 1Ni M M 1 H5			
11 Diameter range:		1,2 - 1,6 mm			
12 Auxiliary materials:		EN ISO 14175 - M2			
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
	S	Gruppe 1.2			
	U	Gruppe 1.2			
	S	Gruppe 1.3 (ReH max. 380 MPa)			
	U	Gruppe 1.3 (ReH max. 460 MPa)			
	U	Gruppe 2.1			
	S	Gruppe 3.1 (ReH max. 380 MPa)			
	U	Gruppe 3.1 (ReH max. 460 MPa)			
	U	St 62 N			(1)
16 Material groups acc. to CR ISO 15608					
21 Root weldability:		verified			
23 Wall thickness:		unbegrenzt			
24 Type of current and polarity:		G+			
25 Welding position according to DIN ISO 6947:		PA, PB, PF			
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:		-40°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) Bei diesem Werkstoff handelt es sich um die Werksmarke eines Anwenders. Ein Einsatz für die Herstellung überwachungsbedürftiger Anlagen nach § 2 Gerätesicherheitsgesetz ist nicht vorgesehen. Bezüglich Zähigkeit liegen keine Gewährleistungswerte vor.					
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 Pfalz			
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					

*) Statements of the manufacturer