

TÜV-Verband Welding Consumable Leaflet

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

		1 Manufacturer/Supplier Ambica Steels India Limited Survey No.-385, Village: Kanaiyabe IND 370020 Taluka: Bhuj, Dist: Kutch, Gujarat			2 Number: 20235.00-	
3 Welding consumable*:		Schweißstab				
4 Trade name*:		ASIL 309L				
7 Type*:		EN ISO 14343-W 23 12 L				
11 Diameter range:		1,2 - 4,0 mm				
12 Auxiliary materials:		EN ISO 14175 - I1				
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	
1	U	Gruppe 8.1 (ohne Mo/ohne N)				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		verified				
23 Wall thickness:		max. 50 mm, Wurzel unbegrenzt / root unlimited				
24 Type of current and polarity:		G-				
25 Welding position according to DIN EN ISO 6947:1997-05: PA, PB, PC, PD, PE, PF, PG						
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 / as parent material		
30 For use in the long-term range:				---		
31 Resistance to intergranular corrosion proven in accordance with:				---		
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 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: TÜV-Verband e. V. Distribution: TÜV-Media GmbH, Am Grauen Stein, 51105 Köln - Unternehmensgruppe TÜV Rheinland Group						