


VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier VENUS WIRE Private Industries Ltd. Office: 19, Raghuvanshi Mill Compound, S. B. Marg, Lower Parel Plant: Khopoli, Maharashtra			2 No. of VdTÜV-Kennblatt: 11926.01 04.2014	
		3 Welding consumable*: Drahtelektrode				
4 Trade name*: VENUS 2209 - MIG						
7 Type*: EN ISO 14343-A - G 22 9 3 N L						
11 Diameter range: 0,8 bis 1,6 mm						
12 Auxiliary materials: EN ISO 14175 - M 13						
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 10.1 (Duplex)				
16 Material groups acc. to CR ISO 15608						
21 Root weldability: not verified						
23 Wall thickness: max. 40 mm						
24 Type of current and polarity: G+						
25 Welding position according to DIN ISO 6947: PA, PC						
26 Highest operating temperature in the short-term range as for parent metal, but not higher than: 250°C						
27 Highest operating temperature in the long-term range max.: - - - °C						
28 Lowest operating temperature/as for parent metal, but not lower than: -80°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: EN ISO 3651-2						
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 - Region Essen						
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