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: 11923.02 04.2014

3 Welding consumable*:	Schweißstab
4 Trade name*:	VENUS 309 LSi - TIG
7 Type*:	EN ISO 14343-A - W 23 12 L Si
11 Diameter range:	1,0 bis 4,0 mm
12 Auxiliary materials:	EN ISO 14175 - I1

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 (ohne Mo)			
	U	Gruppe 8.1 (ohne Mo)	verschweißt mit	Gruppe 1.1	

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, 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:	-120°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:
Prägung der Schweißstäbe: "V 309LSI"

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	S stress-relieved	W soft annealed	G+ direct current plus pole
	L solution annealed and quenched	St stabilized		G- direct current minus pole
	N normalized	U non-annealed		W alternating current
		V hardened and tempered		

35 Compiled in accordance with the data of:	TÜV NORD - Region Essen

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*) Statements of the manufacturer