


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: 20229.00-	
		3 Welding consumable*: Drahtelektrode				
4 Trade name*: ASIL 309L						
7 Type*: EN ISO 14343-A G 23 12 L						
11 Diameter range: 0,8 - 1,6 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						
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	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						
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