


# 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: 11473.00 04.2015	
3 Welding consumable*:		Schweißstab				
4 Trade name*:		VENUS 309 L				
7 Type*:		EN ISO 14343-A W 23 12 L				
11 Diameter range:		1,2 - 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)				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		verified				
23 Wall thickness:		max. 25 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:		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				
30 For use in the long-term range:		- - -				
31 Resistance to intergranular corrosion proven in accordance with:		- - -				
32 Remarks: Präge der Stäbe: VENUS 309L						
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		
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\*) Statements of the manufacturer