

# TÜV-Verband Welding Consumable Leaflet

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

|  |  |   |                 |  |         |
|--|--|---|-----------------|--|---------|
|   | 1 Manufacturer/Supplier<br>PJSC PlasmaTec<br>Maksymovycha str. 18<br>UKR 21036 Vinnytsia | 2 Number:<br>19415.01<br>23.08.2021   |                 |  |         |
| 3 Welding consumable*: Drahtelektrode  |  |   |                 |  |         |
| 4 Trade name*: G3Si1 - TM Monolith   |  |   |                 |  |         |
| 7 Type*: EN ISO 14341-A - G 42 4 M21 3Si1  |  |   |                 |  |         |
| 11 Diameter range: 0,8 - 1,2 mm  |  |   |                 |  |         |
| 12 Auxiliary materials: EN ISO 14175-A - M21   |  |   |                 |  |         |
| 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 |
|  | U  | Gruppe 1.2  |                 |  |         |
| 16 Material groups acc. to CR ISO 15608  |  |   |                 |  |         |
| 21 Root weldability: verified  |  |   |                 |  |         |
| 23 Wall thickness: max. 40 mm  |  |   |                 |  |         |
| 24 Type of current and polarity: G+  |  |   |                 |  |         |
| 25 Welding position according to DIN EN ISO 6947:1997-05: 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:   |  |   | -40 °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:  |  |   | ----            |  |         |
| 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<br>L solution annealed and quenched<br>N normalized                           | S stress-relieved<br>St stabilized<br>U non-annealed<br>V hardened and tempered | W soft annealed | G+ direct current plus pole<br>G- direct current minus pole<br>W alternating current |         |
| 35 Compiled in accordance with the data of: TÜV Rheinland  |  |   |                 |  |         |
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