

TÜV-Verband Welding Consumable Leaflet

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

		1 Manufacturer/Supplier STANVAC INTERNATIONAL LIMITED Plott No. 551, Pace City II, Sector 37 IND 122001 Haryana, Gurgaon			2 Number: 20202.00 08.11.2024	
3 Welding consumable*: Stabelektrode						
4 Trade name*: STAVINOX 2209						
7 Type*: EN ISO 3581-A - E 22 9 3 N L R 1 2						
11 Diameter range: 2,5 - 4,0 mm						
12 Auxiliary materials: - - -						
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 10.1				
	U	Gruppe 10.1	verschweißt mit	Gruppe 8.1		
	U	Gruppe 10.1	verschweißt mit	Gruppe 1.1		
	U	Gruppe 10.1	verschweißt mit	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, PD, PE, PF						
26 Highest operating temperature in the short-term range as for parent metal, but not higher than: 200 °C						
27 Highest operating temperature in the long-term range max.: - - - °C						
28 Lowest operating temperature/as for parent metal, but not lower than: -10 °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 Methode A						
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 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 Rheinland						
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