


# VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier ITW Welding GmbH DEU 67317 Altleiningen		2 No. of VdTÜV-Kennblatt: 19252.01 13.10.2017	
3 Welding consumable*:		Fülldrahtelektrode			
4 Trade name*:		MEGAFIL 550R			
7 Type*:		EN ISO 18276-A: T55 6 Mn1,5Ni P M21 1 H5			
11 Diameter range:		1,2 mm			
12 Auxiliary materials:		EN ISO 14175 - M21			
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 1.1			
	U	Gruppe 1.2			
	U	Gruppe 1.3 (ReH max. 550 MPa)			
	U	Gruppe 2.1			
	U	Gruppe 2.2 (ReH max. 550 MPa)			
	U	Gruppe 3.1 (ReH max. 550 MPa)			
16 Material groups acc. to CR ISO 15608					
21 Root weldability:		not verified			
23 Wall thickness:		unbegrenzt			
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:				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:				-60°C	
29 Design stress value/as for parent metal:			-----		
30 For use in the long-term range:			-----		
31 Resistance to intergranular corrosion proven in accordance with:			-----		
32 Remarks: -----					
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 Pfalz					
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Dieses Kennblatt wurde mit Genehmigung des Herausgebers kostenlos durch die ITW Welding GmbH, 67317 Altleiningen im Jahr 2021 zur Verfügung gestellt.

\*) Statements of the manufacturer