


# VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier VDM Metals GmbH Plettenberger Straße 2 DEU 58791 Werdohl		2 No. of VdTÜV-Kennblatt: 19468.00 06.12.2018	
3 Welding consumable*:		Schweißdraht			
4 Trade name*:		VDM ® FM 660			
7 Type*:		EN ISO 18274 - S Ni 6660 (NiCr22Mo10W3)			
11 Diameter range:		1,0 - 1,2 mm			
12 Auxiliary materials:		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	NiCr22Mo9Nb (W-Nr.2.4856, Werkstoffblatt 499)	verschweißt mit	P275NH - P355NH	
	U	P275NH - P355NH	als Trägerwerkstoff		
16 Material groups acc. to CR ISO 15608					
21 Root weldability:		verified			
23 Wall thickness:		40 mm			
24 Type of current and polarity:		G-			
25 Welding position according to DIN EN ISO 6947:1997-05: PA, PC					
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:				550 (1) °C	
27 Highest operating temperature in the long-term range max.:				--- °C	
28 Lowest operating temperature/as for parent metal, but not lower than:				(2) °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: (1) am reinen Schweißgut ermittelt, zusätzlich wurde bei 400 °C an der Verbindung geprüft (2) am reinen Schweißgut: -196 °C, Verbindung: -20°C					
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	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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\*) Statements of the manufacturer