

# DIN EN ISO 14171:2016-12 (E)

## Welding consumables - Solid wire electrodes, tubular cored electrodes and electrode/flux combinations for submerged arc welding of non alloy and fine grain steels - Classification (ISO 14171:2016)

---

<b>Contents</b>		<b>Page</b>
	European foreword .....	3
	Foreword .....	4
	Introduction .....	5
<b>1</b>	<b>Scope</b> .....	<b>6</b>
<b>2</b>	<b>Normative references</b> .....	<b>6</b>
<b>3</b>	<b>Classification</b> .....	<b>7</b>
<b>4</b>	<b>Symbols and requirements</b> .....	<b>8</b>
4.1	Symbol for the process .....	8
4.2	Symbol for tensile properties .....	8
4.2.1	Multi-run technique .....	8
4.2.2	Two-run technique .....	9
4.3	Symbol for the impact properties of all-weld metal or two-run welded joint .....	10
4.4	Symbol for type of welding flux .....	10
4.5	Symbol for the chemical composition .....	10
4.5.1	Solid wire electrodes .....	10
4.5.2	Tubular cored electrode/flux combinations .....	11
4.6	Symbol for hydrogen content of deposited metal .....	20
<b>5</b>	<b>Mechanical tests</b> .....	<b>20</b>
5.1	Multi-run technique .....	20
5.2	Two-run technique .....	22
<b>6</b>	<b>Chemical analysis</b> .....	<b>22</b>
<b>7</b>	<b>Rounding procedure</b> .....	<b>22</b>
<b>8</b>	<b>Retest</b> .....	<b>23</b>
<b>9</b>	<b>Technical delivery conditions</b> .....	<b>23</b>
<b>10</b>	<b>Examples of designation</b> .....	<b>23</b>