

DIN EN ISO 17633:2018-05 (E)

Welding consumables - Tubular cored electrodes and rods for gas shielded and non-gas shielded metal arc welding of stainless and heat-resisting steels - Classification (ISO 17633:2017)

Contents	Page
European foreword.....	3
Foreword.....	4
Introduction.....	5
1 Scope	6
2 Normative references	6
3 Terms and definitions	6
4 Classification	7
5 Symbols and requirements	7
5.1 General.....	7
5.2 Symbol for the product.....	8
5.3 Symbol for the chemical composition of all-weld metal.....	8
5.4 Symbol for type of core.....	24
5.5 Symbol for shielding gas.....	24
5.6 Symbol for welding position.....	25
6 Mechanical test	25
6.1 Preheating and interpass temperatures.....	25
6.2 Pass sequence.....	26
7 Chemical analysis	26
8 Rounding procedure	26
9 Retests	27
10 Technical delivery conditions	27
11 Examples of designation	27
Annex A (informative) Comparison charts of alloy designation according to nominal composition and alloy type	29
Annex B (informative) Description of types of core — Classification according to nominal composition	31
Annex C (informative) Description of types of tubular cored electrodes and rods — Classification according to alloy type	32
Annex D (informative) Considerations on weld metal ferrite contents	33
Bibliography	36