ISO 3690:2018 (E)

Welding and allied processes — Determination of hydrogen content in arc weld metal

Contents

Foreword

- 1 Scope
- 2 Normative references
- 3 Terms and definitions
- 4 Principle

5 Test procedures

- 5.1 Production of weld specimens
- 5.1.1 Summary
- 5.1.2 Welding fixture
- 5.1.3 Test piece assemblies
- 5.1.4 Welding and test piece storage
- 5.1.5 Recording of data
- 5.2 Welding procedures for the production of weld specimens
- 5.2.1 Summary
- 5.2.2 Manual metal arc welding
- 5.2.2.1 Electrodes
- 5.2.2.2 Making the test welds
- 5.2.2.3 Recording of welding data and results report form
- 5.2.3 Submerged arc welding
- 5.2.3.1 Electrode wire
- 5.2.3.2 Flux
- 5.2.3.3 Making the test welds
- 5.2.3.4 Recording of welding data and results report form
- 5.2.4 Tubular cored electrode with or without gas shield and wire electrode with gas shield
- 5.2.4.1 Filler material
- 5.2.4.2 Shielding gas
- 5.2.4.3 Making the test welds
- 5.2.4.4 Recording of welding data and results report form
- 5.3 Measurement of hydrogen in the test weld
- 5.3.1 General
- 5.3.2 Displacement of mercury method
- 5.3.2.1 Preparation of gas burette
- 5.3.2.2 Test piece cleaning and handling
- 5.3.2.3 Test piece loading
- 5.3.2.4 Analytical procedure
- 5.3.3 Thermal conductivity detector method
- 5.3.3.1 General
- 5.3.3.2 Test piece cleaning and handling
- 5.3.3.3 Test piece loading
- 5.3.3.4 Measurement method by hot carrier gas extraction
- 5.3.3.5 Measurement method for collection and subsequent measurement of hydrogen
- 5.3.4 Calibration
- 5.3.5 Linearity
- 5.3.6 Calculation and expression of results
- 5.3.6.1 Diffusible hydrogen in deposited metal, HD
- 5.3.6.2 Diffusible hydrogen in fused weld metal, HF
- 5.3.7 Reporting of results
- 5.4 Measurement of total hydrogen content in the weld metal Rapid methods

- 5.5 Rounding procedure
- Annex A (informative) Recommendations and restrictions in regard to older methods of measurement using mercury
- Annex B (informative) Recommendations and restrictions in regard to older methods of measurement using glycerine
- Annex C (informative) Accuracy and reproducibility
 - C.1 General
 - C.2 Accuracy
 - C.3 Reproducibility

Page count: 23