

ISO 8249:2018 (E)

Welding — Determination of Ferrite Number (FN) in austenitic and duplex ferritic-austenitic Cr-Ni stainless steel weld metals

Contents

	Foreword
	Introduction
1	Scope
2	Normative references
3	Terms and definitions
4	Principle
5	Calibration
5.1	Coating thickness standards
5.2	Magnet
5.3	Instruments
5.4	Calibration curve
6	Standard method for covered electrode test pads
6.1	Dimensions of weld metal test specimens
6.2	Depositing weld metal test specimens
6.3	Measuring
6.3.1	Surface finishing
6.3.2	Individual measurements
6.3.3	Reporting
7	Standard methods for test pads of other processes and for production welds
7.1	Standard method for test pads for other weld metals
7.2	Production welds
8	Other methods
8.1	Methods
8.2	Maintaining calibration
9	Procedures used to prepare secondary standards for delta ferrite in austenitic stainless steel weld metal
Annex A	(informative) Manufacture of secondary standards by strip cladding
A.1	Materials
A.1.1	Base metal
A.1.2	Welding consumables
A.2	Welding procedures
A.3	Machining and marking
A.3.1	Cutting programme
A.3.2	Dimensions, tolerances, surface finish
A.3.3	Marking for standard identification
A.4	Chemical composition
A.5	Marking for FN measuring point location
A.6	FN measuring instruments and calibration
A.6.1	General
A.6.2	Instruments used
A.6.3	Magnet strength checks
A.6.4	Ferrite Number calibration

- A.7 Measuring procedure on secondary standards**
- A.7.1 Instruments and operators**
- A.7.2 Demagnetization**
- A.7.3 Measurements on each ferrite standard**
- A.7.4 Data recording and analysis**
- A.7.5 Presentation of results**

Annex B (informative) Manufacture of secondary standards by centrifugal chill casting

- B.1 Materials**
- B.2 Machining and marking**
- B.3 FN measuring instruments and calibration**
- B.4 Measuring procedure on secondary standards**
- B.4.1 Instruments and operators**
- B.4.2 Demagnetization**
- B.4.3 Measurements on each ferrite standard**
- B.4.4 Data recording and analysis**
- B.4.5 Presentation of results**

Page count: 27