DIN EN ISO 24598:2019-09 (E)

Welding consumables - Solid wire electrodes, tubular cored electrodes and electrode-flux combinati ons for submerged arc welding of creep-resisting steels - Classification (ISO 24598:2019)

Contents

Page

European foreword ... **3**

Foreword ... **4**

Introduction ... **5**

1 Scope ... **6**

2 Normative references ... **6**

3 Terms and definitions ... **7**

4 Classification ... **7**
4.1 General ... 7

5 Symbols and requirements ... **8**
5.1 General ... 8
5.2 Symbol for the product/process ... 8
5.2.1 General ... 8
5.3 Symbols for the tensile properties of the all-weld metal deposit ... 8
5.4 Symbols for impact properties of all-weld metal deposits ... 9
5.5 Symbol for type of welding flux ... 10
5.6 Symbol for the chemical composition of solid wire electrodes and of all-weld metal deposits ... 10

6 Mechanical tests ... **13**
6.1 General ... 13
6.2 Preheating, interpass and post-weld heat treatment temperatures ... 13
6.3 Welding conditions and pass sequence ... 16
6.3.1 General ... 16

7 Chemical analysis ... **18**

8 Rounding procedure ... **18**

9 Retests ... **18**

10 Technical delivery conditions ... **19**

11 Examples of designation ... **19**
11.1 General ... 19

Bibliography ... **23**