

ISO 16834:2025-02 (E)

Welding consumables - Wire electrodes, wires, rods and deposits for gas shielded arc welding of high strength steels - Classification

Contents		Page
Foreword		iv
Introduction		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	2
4	Classification	2
4.1	General	2
4.2	Classification systems	2
5	Symbols and requirements	3
5.1	Symbols for the product/process	3
5.2	Symbols for strength and elongation properties of all-weld metal	3
5.2.1	Classification by yield strength and 47 J impact energy - System A	3
5.2.2	Classification by tensile strength and 27 J impact energy - System B	3
5.3	Symbol for impact properties of all-weld metal	3
5.3.1	Classification by yield strength and 47 J impact energy - System A	3
5.3.2	Classification by tensile strength and 27 J impact energy - System B	4
5.4	Symbol for shielding gas	4
5.5	Symbol for the chemical composition of wire electrodes, wires and rods	5
5.6	Symbol for condition of post-weld heat treatment	5
5.6.1	Classification by yield strength and 47 J impact energy - System A	5
5.6.2	Classification by tensile strength and 27 J impact energy - System B	5
6	Mechanical tests	10
7	Preheating and interpass temperatures	10
8	Welding conditions and pass sequence	10
8.1	General	10
8.2	Post-weld heat-treated condition	11
8.2.1	Classification by yield strength and 47 J impact energy - System A	11
8.2.2	Classification by tensile strength and 27 J impact energy - System B	11
9	Chemical analysis	11
10	Rounding procedure	11
11	Retest	12
12	Technical delivery conditions	12
13	Examples of designation	12
13.1	General	12
13.2	Example 1 - Classification by yield strength and 47 J impact energy - System A	12
13.3	Example 2 - Classification by tensile strength and 27 J impact energy - System B	13
13.4	Example 3 - Classification by yield strength and 47 J impact energy - System A	13
13.5	Example 4 - Classification by tensile strength and 27 J impact energy - System B	13
13.6	Example 5 - Classification by yield strength and 47 J impact energy - System A	14
13.7	Example 6 - Classification by tensile strength and 27 J impact energy - System B	14
Annex A (informative)	Description of composition designations for electrodes in the classification system based upon tensile strength and average impact energy of 27 J - System B	16
Bibliography		17