

DIN EN ISO 21952:2025-05 (E)

Welding consumables - Wire electrodes, wires, rods and deposits for gas shielded arc welding of creep-resisting steels - Classification (ISO 21952:2025)

Contents		Page
Foreword		iv
Introduction		vi
1 Scope		1
2 Normative references		1
3 Terms and definitions		1
4 Classification		2
4.1 General.....		2
4.2 Classification systems.....		2
5 Symbols and requirements		2
5.1 Symbol for the product or process.....		2
5.2 Symbol for the chemical composition of wire electrodes, wires, and rods.....		3
5.3 Symbol for the mechanical properties of all-weld metal.....		3
5.3.1 Classification by chemical composition – System A.....		3
5.3.2 Classification by tensile strength and chemical composition – System B.....		3
5.4 Symbol for shielding gas.....		3
5.4.1 Classification by chemical composition – system A.....		3
5.4.2 Classification by tensile strength and chemical composition – system B.....		3
6 Mechanical tests		12
7 Preheating and interpass temperatures		12
8 Welding conditions and pass sequence		12
9 Chemical analysis		13
10 Rounding procedure		13
11 Retest		13
12 Technical delivery conditions		13
13 Examples of designation		13
13.1 General.....		13
13.2 Example 1 – Classification by chemical composition – system A.....		13
13.3 Example 2 – Classification by tensile strength and chemical composition – system B.....		14
13.4 Example 3 – Classification by chemical composition – system A.....		14
13.5 Example 4 – Classification by tensile strength and chemical composition – system B.....		14
13.6 Example 5 – Classification by chemical composition – system A.....		15
13.7 Example 6 – Classification by tensile strength and chemical composition – system B.....		15
13.8 Example 7 – Classification by chemical composition – system A.....		15
13.9 Example 8 – Classification by tensile strength and chemical composition – system B.....		16
Bibliography		17