

DIN EN ISO 18275:2026-09 (E)

Welding consumables - Covered electrodes for manual metal arc welding of high-strength steels - Classification (ISO 18275:2026)

Contents

Page

Foreword	v
Introduction	vi
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Classification	2
4.1 General	2
4.2 Classification systems	2
4.3 Compulsory and optional sections	3
4.3.1 General	3
5 Symbols and requirements	3
5.1 Symbol for the product/process	3
5.2 Symbol for tensile properties of all-weld metal	4
5.2.1 System A	4
5.2.2 System B	4
5.3 Symbol for impact properties of all-weld metal	4
5.3.1 System A	4
5.3.2 System B	4
5.4 Symbol for chemical composition of all-weld metal	5
5.4.1 System A	5
5.4.2 System B	6
5.5 Symbol for type of electrode covering	7
5.5.1 System A	7
5.5.2 System B	7
5.6 Symbol for condition of post-weld heat treatment of all-weld metal	8
5.6.1 System A	8
5.6.2 System B	8
5.7 Symbol for electrode efficiency and type of current	8
5.7.1 System A	8
5.7.2 System B	9
5.8 Symbol for welding position	9
5.8.1 System A	9
5.8.2 System B	9
5.9 Symbol for diffusible hydrogen content of deposited metal	9
5.10 Mechanical property and composition requirements	10
5.10.1 System A	10
5.10.2 System B	10
6 Mechanical property tests	15
6.1 General	15
6.2 Preheating and interpass temperatures	15
6.2.1 System A	15
6.2.2 System B	15
6.3 Pass sequence	15
6.3.1 General	15
6.3.2 System A	16
6.3.3 System B	16

7	Chemical analysis	16
7.1	General	16
7.1.1	System A	16
7.1.2	System B	16
8	Rounding procedure	16
9	Retests	16
10	Technical delivery conditions	16
11	Examples of designation	17
11.1	General	17
11.2	Example 1 – System A	17
11.3	Example 2 – System B	17
11.4	Example 3 – System A	18
11.5	Example 4 – System B	19
Annex A (informative)	Classification systems	20
Annex B (informative)	Description of types of electrode covering — System A	22
Annex C (informative)	Description of types of electrode covering — System B	23
Annex D (informative)	Notes on diffusible hydrogen	25
Annex E (informative)	Description of chemical composition symbols — System A	26
Annex F (informative)	Description of chemical composition symbols — System B	27
Bibliography		28