

# DIN EN ISO 17633:2006-06 (E)

## Welding consumables - Tubular cored electrodes and rods for gas shielded and non-gas shielded metal arc welding of stainless and heat-resisting steels - Classification (ISO 17633:2004)

---

<b>Contents</b>		<b>Page</b>
Foreword .....		2
Introduction .....		4
<b>1</b>	<b>Scope .....</b>	<b>5</b>
<b>2</b>	<b>Normative references .....</b>	<b>5</b>
<b>3</b>	<b>Classification .....</b>	<b>6</b>
<b>4</b>	<b>Symbols and requirements .....</b>	<b>7</b>
4.1	Symbol for the product/process .....	7
4.2	Symbol for the chemical composition of all-weld metal .....	7
4.3	Symbol for type of electrode core .....	17
4.4	Symbol for shielding gas .....	17
4.5	Symbol for welding position .....	18
<b>5</b>	<b>Mechanical tests .....</b>	<b>18</b>
5.1	Preheating and interpass temperatures .....	18
5.2	Pass sequence .....	19
<b>6</b>	<b>Chemical analysis .....</b>	<b>19</b>
<b>7</b>	<b>Fillet weld test .....</b>	<b>20</b>
<b>8</b>	<b>Retests .....</b>	<b>21</b>
<b>9</b>	<b>Technical delivery conditions .....</b>	<b>21</b>
<b>10</b>	<b>Examples of designation .....</b>	<b>22</b>
<b>Annex A (informative)</b>	<b>Comparison charts of alloy designation according to nominal composition and alloy type .....</b>	<b>23</b>
<b>Annex B (informative)</b>	<b>Description of types of electrode core -- classification according to nominal composition .....</b>	<b>24</b>
<b>Annex C (informative)</b>	<b>Description of types of tubular cored electrodes and rods -- classification according to alloy type .....</b>	<b>25</b>
<b>Annex D (informative)</b>	<b>Considerations on weld metal ferrite contents [2] .....</b>	<b>26</b>
<b>Bibliography .....</b>		<b>29</b>