

# DIN EN ISO 17632:2008-08 (E)

Welding consumables - Tubular cored electrodes for gas shielded and non-gas shielded metal arc welding of non-alloy and fine grain steels - Classification (ISO 17632:2004)

---

## Contents

Page

Foreword.....	3
Introduction .....	4
1 Scope.....	5
2 Normative references .....	5
3 Classification .....	6
4 Symbols and requirements.....	8
4.1 Symbol for the product/process.....	8
4.2 Symbol for tensile properties of all-weld metal or welded joint .....	8
4.3 Symbol for impact properties of all-weld metal or welded joint .....	9
4.4 Symbol for chemical composition of all-weld metal .....	10
4.5 Symbol for type of electrode core or for the usability characteristics of the electrode.....	13
4.6 Symbol for shielding gas .....	14
4.7 Symbol for welding position.....	16
4.8 Symbol for hydrogen content of deposited metal.....	16
4.9 Symbol for condition of postweld heat treatment of all-weld metal.....	17
5 Mechanical tests .....	17
5.1 Multi-run technique.....	17
5.2 Single-run technique .....	19
6 Chemical analysis .....	19
7 Fillet weld test .....	19
8 Retests .....	20
9 Technical delivery conditions.....	20
10 Examples of designation.....	21
Annex A (informative) Classification systems.....	23
Annex B (informative) Description of types of electrode core in the classification system based upon yield strength and average impact energy of 47 J.....	26
Annex C (informative) Description of types of usability characteristics in the classification system based upon tensile strength and average impact energy of 27 J.....	28
Annex D (informative) Notes on hydrogen content.....	31