

ISO 2560:2009-10 (E)

Welding consumables - Covered electrodes for manual metal arc welding of non-alloy and fine grain steels - Classification

Contents		Page
Foreword		iv
Introduction		v
1	Scope	1
2	Normative references	1
3	Classification	2
4	Symbols and requirements	3
4.1	Symbol for the product/process	3
4.2	Symbols for strength and elongation of all-weld metal	3
4.3	Symbol for impact properties of all-weld metal	4
4.4	Symbol for the chemical composition of all-weld metal	5
4.5	Symbol for type of electrode covering	6
4.6	Symbol for condition of post-weld heat-treatment of all-weld metal	7
4.7	Symbol for nominal electrode efficiency and type of current	7
4.8	Symbol for welding position	8
4.9	Symbol for diffusible hydrogen content of deposited metal	8
5	Mechanical tests	9
5.1	Preheating and interpass temperatures	9
5.2	Pass sequence	13
6	Chemical analysis	13
7	Fillet weld test	16
8	Rounding procedure	18
9	Retests	18
10	Technical delivery conditions	18
11	Examples of designation	19
Annex A (informative) Classification systems		20
Annex B (informative) Description of types of electrode covering -- Classification by yield strength and 47 J impact energy		23
Annex C (informative) Description of types of electrode covering -- Classification by tensile strength and 27 J impact energy		25
Annex D (informative) Notes on diffusible hydrogen and the avoidance of cold cracking		28
Bibliography		29