

DIN EN ISO 17633:2011-03 (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 17633:2010)

Contents		Page
Foreword		3
Introduction		4
1	Scope	5
2	Normative references	5
3	Classification	6
4	Symbols and requirements	6
4.1	Symbol for the product	7
4.2	Symbol for the chemical composition of all-weld metal	7
4.3	Symbol for type of electrode core	20
4.4	Symbol for shielding gas	20
4.5	Symbol for welding position	20
5	Mechanical test	21
5.1	Preheating and interpass temperatures	21
5.2	Pass sequence	22
6	Chemical analysis	22
7	Fillet weld test	22
8	Rounding procedure	23
9	Retests	23
10	Technical delivery conditions	24
11	Examples of designation	24
Annex A (informative) Comparison charts of alloy designation according to nominal composition and alloy type		25
Annex B (informative) Description of types of electrode core -- Classification according to nominal composition		26
Annex C (informative) Description of types of tubular cored electrodes and rods -- Classification according to alloy type		27
Annex D (informative) Considerations on weld metal ferrite contents		28
Bibliography		31