

DIN EN ISO 3581:2012-04 (E)

Welding consumables - Covered electrodes for manual metal arc welding of stainless and heat-resisting steels - Classification (ISO 3581:2003+Cor 1:2008+Amd 1:2011)

| Contents | | Page |
|---|---|-------------|
| Foreword | | 3 |
| Introduction | | 4 |
| 1 | Scope | 5 |
| 2 | Normative references | 5 |
| 3 | Classification | 6 |
| 4 | Symbols and requirements | 9 |
| 4.1 | Symbol for the product/process | 9 |
| 4.2 | Symbol for the chemical composition of all-weld metal | 9 |
| 4.3 | Symbol for type of electrode covering | 9 |
| 4.4 | Symbol for effective electrode efficiency and type of current | 17 |
| 4.5 | Symbol for welding position | 17 |
| 5 | Chemical analysis | 18 |
| 6 | Mechanical property tests | 18 |
| 6.1 | General | 18 |
| 6.2 | Preheat and interpass temperatures | 18 |
| 6.3 | Pass sequence | 19 |
| 7 | Fillet weld test | 19 |
| 8 | Rounding procedure | 20 |
| 9 | Retests | 20 |
| 10 | Technical delivery conditions | 21 |
| 11 | Examples of designation | 21 |
| Annex A (informative) Types of covering | | 22 |
| Annex B (informative) Considerations on weld metal ferrite contents | | 23 |
| Bibliography | | 26 |