DIN EN ISO 17634:2015-12 (E)

Welding consumables - Tubular cored electrodes for gas shielded metal arc welding of creep-resisting steels - Classification (ISO 17634:2015)

Contents

Page

European foreword ... 3

Introduction ... 4

1 Scope ... 5

2 Normative references ... 5

3 Classification ... 6

4 Symbols and requirements ... 7
- 4.1 Symbol for the product/process ... 7
- 4.2 Symbol for the chemical composition of all-weld metal ... 7
- 4.3 Symbol for the mechanical properties of all-weld metal ... 7
- 4.4 Symbol for type of electrode core or the usability characteristics of the electrodes ... 14
- 4.5 Symbol for shielding gas ... 14
- 4.6 Symbol for welding position ... 15
- 4.7 Symbol for hydrogen content of deposited metal ... 15

5 Mechanical tests ... 15
- 5.1 Tensile and impact tests ... 15
- 5.2 Preheating and interpass temperatures ... 16
- 5.3 Pass sequence ... 16

6 Chemical analysis ... 16

7 Rounding procedure ... 16

8 Fillet weld test ... 17

9 Retests ... 18

10 Technical delivery conditions ... 18

11 Example of designation ... 18

Annex A (informative) **Classification systems** ... 21

Annex B (informative) **Description of composition designations of electrode in the classification system based upon tensile strength and chemical composition** ... 23

Annex C (informative) **Description of types of electrode core in the classification system based upon chemical composition** ... 24

Annex D (informative) **Description of types of usability characteristics in the classification system based upon tensile strength and chemical composition** ... 25

Annex E (informative) **Notes on hydrogen content** ... 26

Bibliography ... 27