DIN EN ISO 3581:2018-03 (E)

Welding consumables - Covered electrodes for manual metal arc welding of stainless and h eat-resisting steels - Classification (ISO 3581:2016, Corrected version 2017-11-01)

Contents

Page

European foreword ... **3**

Foreword ... **4**

Introduction ... **5**

1 Scope ... **6**

2 Normative references ... **6**

3 Classification ... **7**

4 Symbols and requirements ... **9**
4.1 Symbol for the product/process ... 9
4.2 Symbol for the chemical composition of all-weld metal ... 10
4.3 Symbol for type of electrode covering ... 10
4.4 Symbol for effective electrode efficiency and type of current ... 18
4.5 Symbol for welding position ... 19

5 Chemical analysis ... **19**

6 Mechanical property tests ... **19**
6.1 General ... 19
6.2 Preheat and interpass temperatures ... 20
6.3 Pass sequence ... 20

7 Fillet weld test ... **21**

8 Rounding procedure ... **21**

9 Retests ... **22**

10 Technical delivery conditions ... **22**

11 Examples of designation ... **22**

Annex A (informative) **Types of covering** ... **24**

Annex B (informative) **Considerations on weld metal ferrite contents** ... **25**

Bibliography ... **28**