

# DIN EN ISO 26304:2018-05 (E)

## Welding consumables - Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of high strength steels - Classification (ISO 26304:2017)

---

<b>Contents</b>		<b>Page</b>
European foreword .....		3
Foreword .....		4
Introduction .....		5
<b>1</b>	<b>Scope</b> .....	<b>6</b>
<b>2</b>	<b>Normative references</b> .....	<b>6</b>
<b>3</b>	<b>Terms and definitions</b> .....	<b>7</b>
<b>4</b>	<b>Classification</b> .....	<b>7</b>
4.1	General .....	7
<b>5</b>	<b>Symbols and requirements</b> .....	<b>8</b>
5.1	General .....	8
5.2	Symbol for the product or process .....	8
5.3	Symbols for the tensile properties of the all-weld metal deposit .....	9
5.4	Symbol for the impact properties of the all-weld metal .....	10
5.5	Symbol for the type of welding flux .....	10
5.6	Symbol for the chemical composition of solid wire electrodes and of the all-weld metal from tubular cored electrode-flux combinations .....	10
5.7	Symbol for the post-weld heat treatment .....	17
5.8	Optional symbol for hydrogen content of deposited metal .....	18
<b>6</b>	<b>Mechanical tests</b> .....	<b>19</b>
6.1	Tensile and impact tests .....	19
6.2	Preheating and interpass temperature .....	19
6.3	Welding conditions and pass sequence .....	19
<b>7</b>	<b>Chemical analysis</b> .....	<b>21</b>
<b>8</b>	<b>Rounding procedure</b> .....	<b>21</b>
<b>9</b>	<b>Retests</b> .....	<b>21</b>
<b>10</b>	<b>Technical delivery conditions</b> .....	<b>21</b>
<b>11</b>	<b>Examples of designation</b> .....	<b>21</b>
<b>Annex A (informative) Possible risk of weld metal hydrogen cracking</b> .....		<b>25</b>
<b>Bibliography</b> .....		<b>26</b>