

ISO 2560:2020 (E)

Welding consumables — Covered electrodes for manual metal arc welding of non-alloy and fine grain steels — Classification

Contents

	Foreword
	Introduction
1	Scope
2	Normative references
3	Terms and definitions
4	Classification
5	Symbols and requirements
5.1	Symbol for the product/process
5.2	Symbols for strength and elongation of all-weld metal
5.3	Symbol for impact properties of all-weld metal
5.4	Symbol for the chemical composition of all-weld metal
5.5	Symbol for type of electrode covering
5.6	Symbol for condition of post-weld heat-treatment of all-weld metal
5.7	Symbol for electrode efficiency and type of current
5.8	Symbol for welding position
5.9	Symbol for diffusible hydrogen content of deposited metal
6	Mechanical tests
6.1	Preheating and interpass temperatures
6.2	Pass sequence
7	Chemical analysis
8	Fillet weld test
9	Rounding procedure
10	Retests
11	Technical delivery conditions
12	Examples of designation
Annex A	(informative) Classification systems
A.1	ISO 2560-A
A.2	ISO 2560-B
Annex B	(informative) Description of types of electrode covering — Classification by yield strength and 47 J impact energy
B.1	General
B.2	Acid-covered electrodes
B.3	Cellulosic-covered electrodes
B.4	Rutile-covered electrodes
B.5	Rutile-thick-covered electrodes
B.6	Rutile-cellulosic-covered electrodes
B.7	Rutile-acid-covered electrodes
B.8	Rutile-basic-covered electrodes

B.9 Basic-covered electrodes

Annex C (informative) Description of types of electrode covering — Classification by tensile strength and 27 J impact energy

C.1	General
C.2	Covering type 03
C.3	Covering type 10
C.4	Covering type 11
C.5	Covering type 12
C.6	Covering type 13
C.7	Covering type 14
C.8	Covering type 15
C.9	Covering type 16
C.10	Covering type 18
C.11	Covering type 19
C.12	Covering type 20
C.13	Covering type 24
C.14	Covering type 27
C.15	Covering type 28
C.16	Covering type 40
C.17	Covering type 45
C.18	Covering type 48

Annex D (informative) Notes on diffusible hydrogen and the avoidance of cold cracking

Page count: 34