

ISO 18276:2024-07 (E)

Welding consumables - Tubular cored electrodes for gas-shielded and non-gas-shielded metal arc welding of high strength steels - Classification

Contents

Page

Foreword.....	v
Introduction.....	vi
1 Scope.....	1
2 Normative references.....	1
3 Terms and definitions.....	2
4 Classification.....	2
4.1 General.....	2
4.2 Classification systems.....	2
4.3 Compulsory and optional sections in classifications.....	3
5 Symbols and requirements.....	4
5.1 Symbol for the product or process.....	4
5.2 Symbol for tensile properties of all-weld metal.....	4
5.3 Symbol for impact properties of all-weld metal.....	5
5.4 Symbol for chemical composition of all-weld metal.....	6
5.5 Symbol for type of electrode core – Classification by yield strength and 47 J impact energy – System A.....	10
5.6 Symbol for usability characteristics of the electrodes – Classification by tensile strength and 27 J impact energy – System B.....	10
5.7 Symbol for shielding gas.....	11
5.8 Symbol for welding position.....	11
5.9 Symbol for hydrogen content of deposited metal.....	11
5.10 Symbol for conditions of post-weld heat treatment.....	12
5.10.1 Classification by yield strength and 47 J impact energy – System A.....	12
5.10.2 Classification by tensile strength and 27 J impact energy – System B.....	12
6 Rounding procedure.....	12
7 Mechanical tests.....	12
7.1 General.....	12
7.2 Preheating and interpass temperatures.....	12
7.3 Pass sequence.....	13
7.4 Post-weld heat treatment (PWHT) condition.....	14
7.4.1 Classification by yield strength and 47 J impact energy – System A.....	14
7.4.2 Classification by tensile strength and 27 J impact energy – System B.....	14
8 Chemical analysis.....	14
9 Retesting.....	14
10 Technical delivery conditions.....	15
11 Examples of designations.....	15
11.1 General.....	15
11.2 Example 1 - Classification by yield strength and 47 J impact energy – System A.....	15
11.3 Example 2 - Classification by tensile strength and 27 J impact energy – System B.....	15
11.4 Example 3 - Classification by yield strength and 47 J impact energy - System A.....	16
11.5 Example 4 - Classification by tensile strength and 27 J impact energy – System B.....	17

Annex A (informative) Classification systems	19
Annex B (informative) Description of composition designations for electrodes in the classification system based upon tensile strength and average impact energy of 27 J - System B	22
Annex C (informative) Description of types of electrode core in the classification system based upon yield strength and average impact energy of 47 J - System A	23
Annex D (informative) Descriptions of types of usability characteristics in the classification system based upon tensile strength and average impact energy of 27 J - System B	24
Annex E (informative) Notes on hydrogen content	26
Bibliography	27