

DIN EN ISO 636:2024-12 (E)

Welding consumables - Rods, wires and deposits for tungsten inert gas welding of non-alloy and fine-grain steels - Classification (ISO 636:2024)

Contents		Page
European foreword.....		3
Foreword.....		4
Introduction.....		5
1	Scope	6
2	Normative references	6
3	Terms and definitions	6
4	Classification	7
	4.1 General.....	7
	4.2 Classification systems.....	7
5	Symbols and requirements	7
	5.1 Symbol for the product/process.....	7
	5.2 Symbol for strength and elongation of all-weld metal.....	7
	5.3 Symbol for impact properties of all-weld metal.....	8
	5.3.1 System A - Classification by yield strength and 47 J impact energy.....	8
	5.3.2 System B - Classification by tensile strength and 27 J impact energy.....	8
	5.4 Symbol for the chemical composition of rods or wires.....	9
6	Mechanical tests	13
	6.1 Mechanical tests and conditions.....	13
	6.2 Preheating and interpass temperatures.....	13
	6.3 Welding conditions and pass sequence.....	14
	6.4 PWHT condition.....	14
7	Chemical analysis	14
8	Rounding procedure	14
9	Retesting	15
10	Technical delivery conditions	15
11	Designation examples	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.....	16
	11.6 Example 4 - Classification by tensile strength and 27 J impact energy - System B.....	17
Bibliography		18