

ISO 17632:2004-10 (E)

Welding consumables - Tubular cored electrodes for gas shielded and non-gas shielded metal arc welding of non-alloy and fine grain steels - Classification

Contents	Page
Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Classification	2
4 Symbols and requirements	4
4.1 Symbol for the product/process	4
4.2 Symbol for tensile properties of all-weld metal or welded joint	4
4.3 Symbol for impact properties of all-weld metal or welded joint	5
4.4 Symbol for chemical composition of all-weld metal	6
4.5 Symbol for type of electrode core or for the usability characteristics of the electrode	9
4.6 Symbol for shielding gas	10
4.7 Symbol for welding position	12
4.8 Symbol for hydrogen content of deposited metal	12
4.9 Symbol for condition of postweld heat treatment of all-weld metal	13
5 Mechanical tests	13
5.1 Multi-run technique	13
5.2 Single-run technique	15
6 Chemical analysis	15
7 Fillet weld test	15
8 Retests	16
9 Technical delivery conditions	16
10 Examples of designation	17
Annex A (informative) Classification systems	19
Annex B (informative) Description of types of electrode core in the classification system based upon yield strength and average impact energy of 47 J	22
Annex C (informative) Description of types of usability characteristics in the classification system based upon tensile strength and average impact energy of 27 J	24
Annex D (informative) Notes on hydrogen content	27