



SLOVENSKI STANDARD

SIST EN ISO 2560:2010

01-april-2010

Nadomešča:
SIST EN ISO 2560:2006

Dodajni materiali za varjenje - Oplaščene elektrode za obločno varjenje nelegiranih in drobnozrnatih jekel - Razvrstitev (ISO 2560:2009)

Welding consumables - Covered electrodes for manual metal arc welding of non-alloy and fine grain steels - Classification (ISO 2560:2009)

Schweißzusätze - Umhüllte Stabelektroden zum Lichtbogenhandschweißen von unlegierten Stählen und Feinkornstählen - Einteilung (ISO 2560:2009)

Produits consommables pour le soudage à l'arc - Électrodes enrobées pour le soudage manuel à l'arc des aciers non alliés et des aciers à grains fins - Classification (ISO 2560:2009)

Ta slovenski standard je istoveten z: EN ISO 2560:2009

ICS:

25.160.20 Potrošni material pri varjenju Welding consumables

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en,fr,de

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN ISO 2560

October 2009

ICS 25.160.20

Supersedes EN ISO 2560:2005

English Version

**Welding consumables - Covered electrodes for manual metal
arc welding of non-alloy and fine grain steels - Classification
(ISO 2560:2009)**

Produits consommables pour le soudage - Électrodes
enrobées pour le soudage manuel à l'arc des aciers non
alliés et des aciers à grains fins - Classification (ISO
2560:2009)

Schweißzusätze - Umhüllte Stabelektroden zum
Lichtbogenhandschweißen von unlegierten Stählen und
Feinkornstählen - Einteilung (ISO 2560:2009)

This European Standard was approved by CEN on 17 September 2009.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN Management Centre has the same status as the official versions.

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Foreword

This document (EN ISO 2560:2009) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding" the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by April 2010, and conflicting national standards shall be withdrawn at the latest by April 2010.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 2560:2005.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

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Endorsement notice

The text of ISO 2560:2009 has been approved by CEN as a EN ISO 2560:2009 without any modification.

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INTERNATIONAL STANDARD

ISO 2560

Third edition
2009-10-15

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

*Produits consommables pour le soudage — Électrodes enrobées pour
le soudage manuel à l'arc des aciers non alliés et des aciers à grains
fins — Classification*

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ISO 2560:2009(E)**Foreword**

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 2560 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*.

This third edition cancels and replaces the second edition (ISO 2560:2002), which has been technically revised.

Requests for official interpretations of any aspect of this International Standard should be directed to the Secretariat of ISO/TC 44/SC 3 via your national standards body. A complete listing of these bodies can be found at www.iso.org.

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Introduction

This International Standard recognizes that there are two somewhat different approaches in the global market to classifying a given electrode, and allows for either or both to be used, to suit a particular market need. Application of either type of classification designation (or of both, where suitable) identifies a product as classified in accordance with this International Standard. The classification in accordance with system A is mainly based on EN 499:1994^[1]. The classification in accordance with system B is mainly based upon standards used around the Pacific Rim.

This International Standard provides a classification in order to designate covered electrodes in terms of the yield strength, tensile strength and elongation of the all-weld metal. The ratio of yield strength to tensile strength of weld metal is generally higher than that of parent metal. Users should note that matching weld metal yield strength to parent metal yield strength does not necessarily ensure that the weld metal tensile strength matches that of the parent metal. Therefore, where the application requires matching tensile strength, selection of the consumable should be made by reference to column 3 of Table 1A or to Table 1B and Table 8B.

It should be noted that the mechanical properties of all-weld metal test specimens used to classify the electrodes vary from those obtained in production joints because of differences in welding procedure such as electrode size, width of weave, welding position, welding current, interpass temperature and parent metal composition.

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

1 Scope

This International Standard specifies requirements for classification of covered electrodes and deposited metal in the as-welded condition and in the post-weld heat-treated condition for manual metal arc welding of non-alloy and fine grain steels with a minimum yield strength of up to 500 MPa or a minimum tensile strength of up to 570 MPa.

This International Standard is a combined specification providing for classification utilizing a system based upon the yield strength and the average impact energy of 47 J of all-weld metal, or utilizing a system based upon the tensile strength and the average impact energy of 27 J of all-weld metal.

- a) Paragraphs and tables which carry the suffix letter "A" are applicable only to covered electrodes classified to the system based upon the yield strength and the average impact energy of 47 J of all-weld metal in this International Standard.
- b) Paragraphs and tables which carry the suffix letter "B" are applicable only to covered electrodes classified to the system based upon the tensile strength and the average impact energy of 27 J of all-weld metal in this International Standard.
- c) Paragraphs and tables which do not have either the suffix letter "A" or the suffix letter "B" are applicable to all covered electrodes classified in this International Standard.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 544, *Welding consumables — Technical delivery conditions for welding filler materials — Type of product, dimensions, tolerances and markings*

ISO 2401, *Covered electrodes — Determination of the efficiency, metal recovery and deposition coefficient*

ISO 3690, *Welding and allied processes — Determination of hydrogen content in ferritic steel arc weld metal*

ISO 6847, *Welding consumables — Deposition of a weld metal pad for chemical analysis*

ISO 6947, *Welds — Welding positions*

ISO 13916, *Welding — Guidance on the measurement of preheating temperature, interpass temperature and preheat maintenance temperature*

ISO 14344, *Welding and allied processes — Procurement of welding consumables*

ISO 15792-1:2000, *Welding consumables — Test methods — Part 1: Test methods for all-weld metal test specimens in steel, nickel and nickel alloys*