SLOVENSKI STANDARD
SIST EN ISO 14171:2011

01-april-2011

Nadomešča:
SIST EN 756:2004

Dodajni in potrošni materiali za varjenje - Žice, strženske žice in kombinacije žica/prašek za obločno varjenje pod praškom nelegiranih in finozrnatih jekel - Razvrstitev (ISO 14171:2010)

Welding consumables - Solid wire electrodes, tubular cored electrodes and electrode/flux combinations for submerged arc welding of non alloy and fine grain steels - Classification (ISO 14171:2010)

Schweißzusätze - Massivdrahtelektroden, Fülldrahtelektroden und Drahtpulver-Kombinationen zum Unterpulverschweißen von unlegierten Stählen und Feinkornstählen - Einteilung (ISO 14171:2010)

Produits consommables pour le soudage - Fils-électrodes pleins, fils-électrodes fourrés et couples fils-flux pour le soudage à l'arc sous flux des aciers non alliés et à grains fins - Classification (ISO 14171:2010)

Ta slovenski standard je istoveten z: **EN ISO 14171:2010**

ICS:

25.160.20 Potrošni material pri varjenju Welding consumables

SIST EN ISO 14171:2011 **en,fr**

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN ISO 14171

October 2010

ICS 25.160.20

Supersedes EN 756:2004

English Version

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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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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

Management Centre: Avenue Marnix 17, B-1000 Brussels

Ref. No. EN ISO 14171:2010: E

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Foreword

The text of ISO 14171:2010 has been prepared by Technical Committee ISO/TC 44 “Welding and allied processes” of the International Organization for Standardization (ISO) and has been taken over as EN ISO 14171:2010 by 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of an identical text or by endorsement, at the latest by April 2011, and conflicting national standards shall be withdrawn at the latest by April 2011.

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.

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Endorsement notice

The text of ISO 14171:2010 has been approved by CEN as a EN ISO 14171:2010 without any modification.

INTERNATIONAL STANDARD

ISO 14171

Second edition
2010-10-01

Welding consumables — Solid wire electrodes, tubular cored electrodes and electrode/flux combinations for submerged arc welding of non alloy and fine grain steels — Classification

Produits consommables pour le soudage — Fils-électrodes pleins, fils-électrodes fourrés et couples fils-flux pour le soudage à l'arc sous flux des aciers non alliés et à grains fins — Classification

Reference number
ISO 14171:2010(E)

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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 14171 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*.

This second edition cancels and replaces the first edition (ISO 14171:2002), 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.

Introduction

This International Standard recognizes that there are two somewhat different approaches in the global market to classifying a given electrode/flux combination, 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.

This International Standard provides a classification system for the designation of solid wire electrodes in terms of their chemical composition, tubular cored electrodes in terms of the deposit composition obtained with a particular submerged arc flux and, where required, electrode/flux combinations in terms of the yield strength, tensile strength and elongation of the all-weld metal deposit. The ratio of yield to tensile strength of weld metal is generally higher than that of parent material. Users should note that matching weld metal yield strength to parent material yield strength does not necessarily ensure that the weld metal tensile strength matches that of the parent material. Thus, where the application of the material requires matching tensile strengths, selection of the consumable should be made by reference to column 3 of Table 1A or 1B, as appropriate.

Although combinations of electrodes and fluxes supplied by individual companies may have the same classification, the individual wire electrodes and fluxes from different companies are not interchangeable unless verified in accordance with this International Standard.

The mechanical properties of all-weld metal test specimens used to classify the electrode/flux combinations vary from those obtained in production joints because of differences in welding procedures such as electrode size and parent material composition.