



SLOVENSKI STANDARD SIST EN ISO 636:2008

01-september-2008

BUXca Yý U
SIST EN 1668:1999

8 cXUbj'a UHfjU]nUj UfYbY!'DU]WZy]W]b']gh]j U]df]j UfYb' bYY[]fUb]]b
XfcVbcnfbU] \ 'Y_Y'dc'H; '!FUnj fgh]h]j fGC '*' *.&\$\$(£

Welding consumables - Rods, wires and deposits for tungsten inert gas welding of non-alloy and fine-grain steels - Classification (ISO 636:2004)

Schweißzusätze - Stäbe, Drähte und Schweißgut zum Wolfram-Inertgasschweißen von unlegierten Stählen und Feinkornstählen - Einteilung (ISO 636:2004)

Produits consommables pour le soudage TIG des aciers non alliés et des aciers à grains fins - Classification (ISO 636:2004)

Ta slovenski standard je istoveten z: EN ISO 636:2008

ICS:

25.160.20 Potrošni material pri varjenju Welding consumables

SIST EN ISO 636:2008

en,fr,de

iTeh STANDARD PREVIEW
(standards.iteh.ai)

SIST EN ISO 636:2008

<https://standards.iteh.ai/catalog/standards/sist/abd189b5-365f-478d-a78e-cf01c644076a/sist-en-iso-636-2008>

English Version

Welding consumables - Rods, wires and deposits for tungsten inert gas welding of non-alloy and fine-grain steels - Classification (ISO 636:2004)

Produits consommables pour le soudage - Baguettes et fils pour dépôts par soudage TIG des aciers non alliés et des aciers à grains fins - Classification (ISO 636:2004)

Schweißzusätze - Stäbe, Drähte und Schweißgut zum Wolfram-Inertgasschweißen von unlegierten Stählen und Feinkornstählen - Einteilung (ISO 636:2004)

This European Standard was approved by CEN on 5 April 2008.

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.

CEN members are the national standards bodies of 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 United Kingdom.

<https://standards.iteh.ai/catalog/standards/sist/abd187b5-365f-478d-a78e-cf01c644076a/sist-en-iso-636-2008>



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

Management Centre: rue de Stassart, 36 B-1050 Brussels

Contents

Page

Foreword.....3

iTeh STANDARD PREVIEW
(standards.iteh.ai)

SIST EN ISO 636:2008

<https://standards.iteh.ai/catalog/standards/sist/abd189b5-365f-478d-a78e-cf01c644076a/sist-en-iso-636-2008>

Foreword

The text of ISO 636:2004 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 636:2008 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 November 2008, and conflicting national standards shall be withdrawn at the latest by November 2008.

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 1668:1997.

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.

iTeh STANDARD PREVIEW
(standards.iteh.ai)
Endorsement notice

The text of ISO 636:2004 has been approved by CEN as a EN ISO 636:2008 without any modification.

[SIST EN ISO 636:2008
https://standards.iteh.ai/catalog/standards/sist/abd189b5-365f-478d-a78e-cf01c644076a/sist-en-iso-636-2008](https://standards.iteh.ai/catalog/standards/sist/abd189b5-365f-478d-a78e-cf01c644076a/sist-en-iso-636-2008)

iTeh STANDARD PREVIEW
(standards.iteh.ai)

SIST EN ISO 636:2008

<https://standards.iteh.ai/catalog/standards/sist/abd189b5-365f-478d-a78e-cf01c644076a/sist-en-iso-636-2008>

**Welding consumables — Rods, wires and
deposits for tungsten inert gas welding of
non-alloy and fine-grain steels —
Classification**

*Produits consommables pour le soudage — Baguettes et fils pour
déposés par soudage TIG des aciers non alliés et des aciers à grains
fins — Classification*

**iTeh STANDARD REVIEW
(standards.iteh.ai)**

[SIST EN ISO 636:2008](https://standards.iteh.ai/catalog/standards/sist/abd189b5-365f-478d-a78e-cf01c644076a/sist-en-iso-636-2008)

[https://standards.iteh.ai/catalog/standards/sist/abd189b5-365f-478d-a78e-
cf01c644076a/sist-en-iso-636-2008](https://standards.iteh.ai/catalog/standards/sist/abd189b5-365f-478d-a78e-cf01c644076a/sist-en-iso-636-2008)



PDF disclaimer

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

iTeh STANDARD PREVIEW
(standards.iteh.ai)

SIST EN ISO 636:2008

<https://standards.iteh.ai/catalog/standards/sist/abd189b5-365f-478d-a78e-cf01c644076a/sist-en-iso-636-2008>

© ISO 2004

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

Contents

Page

Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Classification	2
4 Symbols and requirements	2
4.1 Symbol for the product/process	2
4.2 Symbol for strength and elongation of all-weld metal	2
4.3 Symbol for impact properties of all-weld metal	3
4.4 Symbol for the chemical composition of rods or wires	4
5 Mechanical tests	8
5.1 Preheating and interpass temperatures	8
5.2 Welding conditions and pass sequence	9
5.3 PWHT condition	9
6 Chemical analysis	9
7 Retests	9
8 Technical delivery conditions	10
9 Designation	10

ITeCh STANDARD PREVIEW
 (standards.iteh.ai)
<https://standards.iteh.ai/catalog/standards/sist/abd189b5-365f-478d-a78e-cf01c644076a/sist-en-iso-636-2008>

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 636 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 636:1989), which has been technically revised.

iTeh STANDARD PREVIEW
(standards.iteh.ai)

SIST EN ISO 636:2008

<https://standards.iteh.ai/catalog/standards/sist/abd189b5-365f-478d-a78e-cf01c644076a/sist-en-iso-636-2008>

Introduction

This International Standard provides a classification for the designation of rods and wires in terms of their chemical composition and, where required, in terms of the yield strength, tensile strength and elongation of the all-weld metal. The ratio of yield 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 will not necessarily ensure that the weld metal tensile strength matches that of the parent material. Where the application requires matching tensile strengths, selection of consumable should be made by reference to column 3 of Table 1A or Table 1B.

It should be noted that the mechanical properties of all-weld metal test specimens used to classify the rods and wires vary from those obtained in production joints because of differences in welding procedure such as diameter, width of weave, welding position and material composition.

The classification according to system A is mainly based on EN 1668:1997, *Welding consumables — Rods, wires and deposits for tungsten inert gas welding of non alloy and fine grain steels — Classification*. The classification according to system B is mainly based upon standards used around the Pacific Rim.

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 which can be found at www.iso.org.

iTeh STANDARD PREVIEW
(standards.iteh.ai)

SIST EN ISO 636:2008

<https://standards.iteh.ai/catalog/standards/sist/abd189b5-365f-478d-a78e-cf01c644076a/sist-en-iso-636-2008>