



SLOVENSKI STANDARD SIST EN ISO 26304:2011

01-oktober-2011

Nadomešča:
SIST EN ISO 26304:2011

Dodajni in potrošni materiali za varjenje - Žice, strženske žice in kombinacije žic in praškov za varjenje visokotrdnih jekel po EPP - Razvrstitev (ISO 26304:2011)

Welding consumables - Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of high strength steels - Classification (ISO 26304:2011)

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Schweißzusätze - Massivdrahtelektroden, Fülldrahtelektroden und Draht-Pulver-Kombinationen zum Unterpulverschweißen von hochfesten Stählen - Einteilung (ISO 26304:2011)

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Produits consommables pour le soudage - Fils-électrodes pleins, fils-électrodes fourrés et couples électrodes-flux pour le soudage à l'arc sous flux des aciers à haute résistance - Classification (ISO 26304:2011)

Ta slovenski standard je istoveten z: EN ISO 26304:2011

ICS:

25.160.20 Potrošni material pri varjenju Welding consumables

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EUROPEAN STANDARD
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EUROPÄISCHE NORM

EN ISO 26304

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ICS 25.160.20

Supersedes EN ISO 26304:2009

English Version

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This European Standard was approved by CEN on 11 July 2011.

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-CENELEC 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-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, 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.



EUROPEAN COMMITTEE FOR STANDARDIZATION
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Foreword

This document (EN ISO 26304:2011) 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 February 2012, and conflicting national standards shall be withdrawn at the latest by February 2012.

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 26304:2009.

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, Croatia, 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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The text of ISO 26304:2011 has been approved by CEN as a EN ISO 26304:2011 without any modification.

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INTERNATIONAL STANDARD

ISO 26304

Second edition
2011-08-01

Welding consumables — Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of high strength steels — Classification

*Produits consommables pour le soudage — Fils-électrodes pleins, fils-
électrodes fourrés et couples électrodes-flux pour le soudage à l'arc
sous flux des aciers à haute résistance — Classification*

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ISO 26304:2011(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 26304 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 26304:2008), of which it constitutes a minor revision. It also incorporates the Technical Corrigendum ISO 26304:2008/Cor.1:2009.

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 wire electrode, tubular cored electrode, and 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. The classification in accordance with system A is mainly based on EN 14295^[3]. The classification in accordance with system B is mainly based upon standards used around the Pacific Rim. Future revisions aim to merge the two approaches into a single classification system.

This International Standard provides a classification 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, elongation, and impact properties 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 metal yield strength does not necessarily ensure that the weld metal tensile strength matches that of the parent material. Thus, where the application requires matching tensile strength, selection of the consumable should be made by reference to column 3 of Table 1A or Table 1B, as appropriate.

Although combinations of electrodes and fluxes supplied by individual companies may have the same classification, the combination of an electrode with a flux from one manufacturer versus the flux from another manufacturer, both fluxes having the same classification, may not be interchangeable unless verified in accordance with this International Standard. Two tubular cored wires of the same classification may likewise produce different results with the same flux.

The mechanical properties of the 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, width of weave, welding position, and material composition.

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