



# SLOVENSKI STANDARD SIST EN ISO 17634:2015

01-oktober-2015

Nadomešča:  
SIST EN ISO 17634:2006

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**Dodajni materiali za varjenje - Strženske žice iz cevi za obločno varjenje jekel, odpornih proti lezenju, v zaščitnem plinu - Razvrščanje (ISO 17634:2015)**

Welding consumables - Tubular cored electrodes for gas shielded metal arc welding of creep-resisting steels - Classification (ISO 17634:2015)

Schweißzusätze - Fülldrahtelektroden zum Metall-Schutzgasschweißen von warmfesten Stählen - Einteilung (ISO 17634:2015)

Produits consommables pour le soudage - Fils-électrodes fourrés pour le soudage à l'arc avec gaz de protection des aciers résistant au fluage - Classification (ISO 17634:2015)

**Ta slovenski standard je istoveten z: EN ISO 17634:2015**

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**ICS:**

25.160.20      Potrošni material pri varjenju      Welding consumables

**SIST EN ISO 17634:2015**

**en,fr,de**

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EUROPEAN STANDARD

EN ISO 17634

NORME EUROPÉENNE

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ICS 25.160.20

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English Version

## Welding consumables - Tubular cored electrodes for gas shielded metal arc welding of creep-resisting steels - Classification (ISO 17634:2015)

Produits consommables pour le soudage - Fils-électrodes fourrés pour le soudage à l'arc avec gaz de protection des aciers résistant au fluage - Classification (ISO 17634:2015)

Schweißzusätze - Fülldrahtelektroden zum Metall-Schutzgasschweißen von warmfesten Stählen - Einteilung (ISO 17634:2015)

This European Standard was approved by CEN on 11 August 2015.

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

**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**

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## European foreword

This document (EN ISO 17634:2015) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding and allied processes" 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 2016, and conflicting national standards shall be withdrawn at the latest by February 2016.

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INTERNATIONAL  
STANDARD

ISO  
17634

Second edition  
2015-08-01

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**Welding consumables — Tubular  
cored electrodes for gas shielded  
metal arc welding of creep-resisting  
steels — Classification**

*Produits consommables pour le soudage — Fils-électrodes fourrés  
pour le soudage à l'arc avec gaz de protection des aciers résistant au  
fluage — Classification*

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**ISO 17634:2015(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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

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. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*.

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](http://www.iso.org).

This second edition cancels and replaces the first edition (ISO 17634:2004), which has been technically revised.

## Introduction

This International Standard provides a classification system for tubular cored electrodes in terms of chemical composition of the all-weld metal, type of electrode core, type of shielding gas, and welding position or in terms of the tensile properties, chemical composition of the all-weld metal, usability characteristics of the electrodes, shielding gas, and welding position. The ratio of proof to tensile strength of weld metal is generally higher than that of parent metal. Matching weld metal proof strength to parent metal proof strength will not necessarily ensure that the weld metal tensile strength matches that of the parent metal. Where the application requires matching tensile strength, therefore, selection of consumables is made by reference to column 4 of [Table 2](#).

Of note is that the mechanical properties of all-weld metal test specimens used to classify the tubular cored electrodes will vary from those obtained in production joints because of differences in welding procedure such as electrode size, width of weave, welding position, and parent metal composition.

The classification according to system A is mainly based on EN 12071:1999. The classification according to system B is mainly based upon standards used around the Pacific Rim.

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