

---

---

**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*

iTeh STANDARD PDF VIEW  
(standards.itih.ai)

[ISO 26304:2011](https://standards.itih.ai/catalog/standards/sist/2daf9c53-8635-404f-873e-ce1b23add390/iso-26304-2011)

[https://standards.itih.ai/catalog/standards/sist/2daf9c53-8635-404f-873e-  
ce1b23add390/iso-26304-2011](https://standards.itih.ai/catalog/standards/sist/2daf9c53-8635-404f-873e-ce1b23add390/iso-26304-2011)



## iTeh STANDARD PREVIEW (standards.iteh.ai)

ISO 26304:2011

<https://standards.iteh.ai/catalog/standards/sist/2daf9c53-8635-404f-873e-ce1b23add390/iso-26304-2011>



### **COPYRIGHT PROTECTED DOCUMENT**

© ISO 2011

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](mailto:copyright@iso.org)  
Web [www.iso.org](http://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 .....	3
4.1 Symbol for the product or process .....	3
4.2 Symbols for the tensile properties of the all-weld metal deposit.....	3
4.3 Symbol for the impact properties of the all-weld metal .....	4
4.4 Symbol for the type of welding flux.....	5
4.5 Symbol for the chemical composition of solid wire electrodes and of the all-weld metal from tubular cored electrode-flux combinations .....	5
4.6 Symbol for the post-weld heat treatment.....	11
4.7 Symbol for hydrogen content of deposited metal .....	12
5 Mechanical tests .....	13
5.1 Tensile and impact tests.....	13
5.2 Preheating and interpass temperature.....	13
5.3 Welding conditions and pass sequence .....	13
6 Chemical analysis .....	14
7 Rounding procedure .....	14
8 Retests.....	15
9 Technical delivery conditions .....	15
10 Examples of designation .....	15
Annex A (informative) Possible risk of weld metal hydrogen cracking .....	17
Bibliography.....	18

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

iTeh STANDARD PREVIEW  
(standards.iteh.ai)  
ISO 26304:2011  
<https://standards.iteh.ai/catalog/standards/sist/2daf9c53-8635-404f-873e-ce1b23add390/iso-26304-2011>

## 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<sup>[3]</sup>. 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.

[ISO 26304:2011](http://standards.iteh.ai/catalog/standards/sist/d051-8635-4046873-1/iso-26304-2011)

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.

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

ISO 26304:2011

<https://standards.iteh.ai/catalog/standards/sist/2daf9c53-8635-404f-873e-ce1b23add390/iso-26304-2011>

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

## 1 Scope

This International Standard specifies requirements for classification of solid wire electrodes, tubular cored electrodes, and electrode-flux combinations (the all-weld metal deposits) in the as-welded condition and in the post-weld heat-treated condition for submerged arc welding of high strength steels with a minimum yield strength greater than 500 MPa or a minimum tensile strength greater than 570 MPa. One flux can be tested and classified with different electrodes. One electrode can be tested and classified with different fluxes. The solid wire electrode is also classified separately based on its chemical composition.

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

- a) Clauses, subclauses and tables which carry the suffix letter “A” are applicable only to solid wire electrodes, tubular cored electrodes and the all-weld metal deposits classified to the system based upon the yield strength and the average impact energy of 47 J for the all-weld metal obtained with electrode-flux combinations in accordance with this International Standard.
- b) Clauses, subclauses and tables which carry the suffix letter “B” are applicable only to solid wire electrodes, tubular cored electrodes and the all-weld metal deposits classified to the system based upon the tensile strength and the average impact energy of 27 J for the all-weld metal obtained with electrode-flux combinations in accordance with this International Standard.
- c) Clauses, subclauses and tables which do not have either the suffix letter “A” or the suffix letter “B” are applicable to all solid wire electrodes, tubular cored electrodes and electrode-flux combinations classified in accordance with this International Standard.

For comparison purposes, some tables include requirements for electrodes classified in accordance with both systems, placing individual electrodes from the two systems, which are similar in composition and properties, on adjacent lines in the particular table. In a particular line of the table that is mandatory in one system, the symbol for the similar electrode from the other system is indicated in parentheses. By appropriate restriction of the formulation of a particular electrode, it is often, but not always, possible to produce an electrode that can be classified in both systems, in which case the electrode, or its packaging, may be marked with the classification in either or both systems.

## 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 filler materials and fluxes — Type of product, dimensions, tolerances and markings*

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

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

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

ISO 14174, *Welding consumables — Fluxes for submerged arc welding and electroslag welding — Classification*

ISO 14344, *Welding consumables — Procurement of filler materials and fluxes*

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

ISO 80000-1:2009, *Quantities and units — Part 1: General*

### 3 Classification

Classification designations are based upon two approaches to indicate the tensile properties and the impact properties of the all-weld metal obtained with a given electrode-flux combination. The two designation approaches include additional designators for the chemical composition of a solid wire electrode or the chemical composition of the all-weld metal deposit obtained with a tubular cored electrode and a particular flux. The two designation approaches include additional designators for some other classification requirements, but not all, as is clear from the following clauses. A given commercial product may be classified to the classification requirements in both systems; then either or both classification designations may be used for the product.

The classification includes the all-weld metal properties obtained with a specific electrode-flux combination as given in 3A and 3B. A solid wire electrode shall be classified in accordance with its chemical composition in Table 3.

A tubular cored electrode shall be classified in accordance with the all-weld metal deposit composition in Table 4, obtained with a particular flux.

When the solid wire electrode or tubular cored electrode is classified in combination with a flux for submerged arc welding, the classification shall be prefixed with a symbol in accordance with Clause 4 as appropriate.

#### 3A Classification by yield strength and 47 J impact energy

The classification is divided into seven parts:

- 1) the first part gives a symbol indicating the product or process to be identified;
- 2) the second part gives a symbol indicating the tensile properties of the all-weld metal (see Table 1A);
- 3) the third part gives a symbol indicating the impact properties of the all-weld metal (see Table 2);

#### 3B Classification by tensile strength and 27 J impact energy

The classification is divided into six parts:

- 1) the first part gives a symbol indicating the product or process to be identified;
- 2) the second part gives a symbol indicating the strength and elongation of the the all-weld metal in either the as-welded or the post-weld heat-treated condition (see Table 1B);
- 3) the third part gives a symbol indicating the impact properties of the all-weld metal in the same condition as specified for the tensile strength (see Table 2). The letter “U” after this designator indicates that the deposit meets an average optional requirement of 47 J at the designated impact test temperature;



- |   |   |
|---|---|
| <p>4) the fourth part gives a symbol indicating the type of flux used (see 4.4);</p> <p>5) the fifth part gives a symbol indicating the chemical composition of the solid wire electrode used (see Table 3) or of the all-weld metal deposited by a tubular cored electrode-flux combination (see Table 4);</p> <p>6) the sixth part gives a symbol indicating the stress relief treatment if this is applied;</p> <p>7) the seventh part gives a symbol indicating the diffusible hydrogen content of the weld metal obtained in accordance with ISO 3690.</p> | <p>4) the fourth part gives a symbol indicating the type of flux used (see 4.4);</p> <p>5) the fifth part gives a symbol indicating the chemical composition of the solid wire electrode used (see Table 3), or of the all-weld metal deposited by a tubular cored electrode-flux combination (see Table 4);</p> <p>6) the sixth part gives a symbol indicating the diffusible hydrogen content of the weld metal obtained in accordance with ISO 3690.</p> |
|---|---|

## 4 Symbols and requirements

A solid wire electrode can be classified separately based upon its chemical composition, as specified in Table 3. The all-weld metal deposit composition and mechanical properties obtained with a particular solid wire electrode or tubular cored electrode vary somewhat depending upon the flux used. Accordingly, the classification of the all-weld metal deposit obtained with a particular solid wire electrode or tubular cored electrode may be different for different fluxes. However, deposit composition is only a classification requirement for tubular cored electrode-flux combinations.

### 4.1 Symbol for the product or process

The symbol for the electrode-flux combination or weld deposit produced by a solid wire electrode or by a tubular cored electrode using the submerged arc welding process with a particular flux, shall be the letter "S" placed at the beginning of the designation. [ISO 26304:2011](https://standards.iteh.ai/catalog/standards/sist/2daf9c53-8635-404f-873e-ce1b23add390/iso-26304-2011)

#### 4.1A Classification by yield strength and 47 J impact energy

The symbol for the solid wire electrode for use in the submerged arc welding process shall be the letter "S" placed at the beginning of the solid wire electrode designation.

The symbol for the tubular cored electrode for use in the submerged arc welding process shall be the letter "T" placed at the beginning of the tubular cored electrode designation.

#### 4.1B Classification by tensile strength and 27 J impact energy

The symbol for the solid wire electrode for use in the submerged arc welding process shall be the letters "SU" placed at the beginning of the solid wire electrode designation.

The symbol for the tubular cored electrode for use in the submerged arc welding process shall be the letters "TU" placed at the beginning of the tubular cored electrode designation.

## 4.2 Symbols for the tensile properties of the all-weld metal deposit

### 4.2A Classification by yield strength and 47 J impact energy

The symbols in Table 1A indicate the yield strength, tensile strength, and elongation of the all-weld metal in the as-welded condition or after stress relief treatment in accordance with 4.6A, determined in accordance with Clause 5 (A-side).

### 4.2B Classification by tensile strength and 27 J impact energy

The symbols in Table 1B indicate the tensile strength, yield strength, and elongation of the all-weld metal in the as-welded condition or in the post-weld heat-treated condition in accordance with 4.6B, determined in accordance with Clause 5 (B-side), with a particular flux.

**Table 1A — Symbol for the tensile properties**  
(Classification by yield strength and 47 J impact energy)

Symbol	Minimum <sup>a</sup> yield strength MPa	Tensile strength MPa	Minimum <sup>b</sup> elongation %
55	550	640 to 820	18
62	620	700 to 890	18
69	690	770 to 940	17
79	790	880 to 1 080	16
89	890	940 to 1 180	15

<sup>a</sup> For yield strength, the lower yield strength,  $R_{eL}$ , is used when yielding occurs, otherwise the 0,2 % proof strength,  $R_{p0,2}$ , is used.

<sup>b</sup> Gauge length is equal to five times the test specimen diameter.

**Table 1B — Symbol for the tensile properties**  
(Classification by tensile strength and 27 J impact energy)

Symbol <sup>a</sup>	Minimum yield strength <sup>b</sup> MPa	Tensile strength MPa	Minimum elongation <sup>c</sup> %
59X	490	590 to 790	16
62X	500	620 to 820	15
69X	550	690 to 890	14
76X	670	760 to 960	13
78X	670	780 to 980	13
83X	740	830 to 1 030	12

<sup>a</sup> X is "A" or "P", where "A" indicates testing in the as-welded condition and "P" indicates testing in the post-weld heat-treated condition

<sup>b</sup> For yield strength, the 0,2 % proof strength,  $R_{p0,2}$ , is used.

<sup>c</sup> Gauge length is equal to five times the test specimen diameter.

**4.3 Symbol for the impact properties of the all-weld metal**

The symbols in Table 2 indicate the temperature at which an average impact energy of 47 J or 27 J is achieved under the conditions given in Clause 5 in the as-welded condition or after post-weld heat treatment.

**Table 2 — Symbol for the impact properties of the all-weld metal**

Symbol	Temperature for minimum average impact energy of 47 J <sup>a</sup> or 27 J <sup>b</sup> °C
Z	No requirements
A <sup>a</sup> or Y <sup>b</sup>	+20
0	0
2	-20
3	-30
4	-40
5	-50
6	-60

<sup>a</sup> When classified in accordance with 4.3A.

<sup>b</sup> When classified in accordance with 4.3B.

#### 4.3A Classification by yield strength and 47 J impact energy

Three test specimens shall be tested. The average value shall be at least 47 J. Only one individual value may be lower than 47 J but not lower than 32 J.

#### 4.3B Classification by tensile strength and 27 J impact energy

Five test specimens shall be tested. The lowest and highest values obtained shall be disregarded. Two of the three remaining values shall be greater than the specified 27 J level, one of the three may be lower but shall not be less than 20 J. The average of the three remaining values shall be at least 27 J.

The addition of the optional symbol U, immediately after the symbol for condition of heat treatment, indicates that the supplemental requirement of 47 J impact energy at the normal 27 J impact test temperature has also been satisfied. For the 47 J impact requirement, the number of specimens tested and values obtained shall meet the requirements of 4.3A.

#### 4.4 Symbol for the type of welding flux

The symbols for welding flux shall be in accordance with ISO 14174.

#### 4.5 Symbol for the chemical composition of solid wire electrodes and of the all-weld metal from tubular cored electrode-flux combinations

The symbols in Table 3 indicate the chemical composition of the solid wire electrode, determined under the conditions given in Clause 6.

The symbols in Table 4 indicate the chemical composition of the all-weld metal deposit obtained with the tubular cored electrode and a particular flux, determined under the conditions given in Clause 6.