

# SLOVENSKI STANDARD

## SIST EN ISO 24598:2019

01-september-2019

Nadomešča:

SIST EN ISO 24598:2012

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**Dodajni materiali za varjenje - Masivne žice, strženske žice in kombinacije žic in praškov za obločno varjenje pod praškom jekel, odpornih proti lezenju - Razvrstitev (ISO 24598:2019)**

Welding consumables - Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of creep-resisting steels - Classification (ISO 24598:2019)

**iTeh STANDARD PREVIEW**

Schweißzusätze - Drahtelektroden, Fülldrahtelektroden und Draht-Pulver-Kombinationen für das Unterpulverschweißen von warmfesten Stählen - Einteilung (ISO 24598:2019)

[SIST EN ISO 24598:2019](https://standards.iteh.ai/catalog/standards/sist/7eb67081-1813-4441-ac08-4201582074/sist-en-iso-24598-2019)

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 résistant au fluage - Classification (ISO 24598:2019)

**Ta slovenski standard je istoveten z: EN ISO 24598:2019**

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**ICS:**

25.160.20      Potrošni material pri varjenju      Welding consumables

**SIST EN ISO 24598:2019**

**en,fr,de**

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN ISO 24598**

May 2019

ICS 25.160.20

Supersedes EN ISO 24598:2012

English Version

**Welding consumables - Solid wire electrodes, tubular  
cored electrodes and electrode-flux combinations for  
submerged arc welding of creep-resisting steels -  
Classification (ISO 24598:2019)**

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 résistant au fluage - Classification (ISO  
24598:2019)

Schweißzusätze - Drahtelektroden,  
Fülldrahtelektroden und Draht-Pulver-Kombinationen  
für das Unterpulverschweißen von warmfesten Stählen  
- Einteilung (ISO 24598:2019)

This European Standard was approved by CEN on 10 May 2019.

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, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



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

**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

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## European foreword

This document (EN ISO 24598:2019) 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 November 2019, and conflicting national standards shall be withdrawn at the latest by November 2019.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 24598:2012.

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, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

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The text of ISO 24598:2019 has been approved by CEN as EN ISO 24598:2019 without any modification.

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INTERNATIONAL  
STANDARDISO  
24598Third edition  
2019-04

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

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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 résistant au fluage — Classification*

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Reference number  
ISO 24598:2019(E)

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Published in Switzerland



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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.

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)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document 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 24598:2012), which has been technically revised. The main changes compared to the previous edition are as follows:

- US classifications have been added to [Table 3](#) and [Table 4](#);
- US classifications have been corrected;
- in [Table 3](#), footnote <sup>h</sup> has been revised;
- in [Table 4](#), footnote <sup>f</sup> has been revised;
- alloy symbols 2M3, 2M31, 3M3 and 4M32 have been removed from Table 5B;
- Tables 6A and 6B have been revised;
- Z-example has been added to [Clause 11](#).

Any feedback, question or request for official interpretation related to any aspect of this document 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/members.html](http://www.iso.org/members.html). Official interpretations, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>.

## Introduction

This document recognizes that there are two somewhat different approaches in the global market to classifying a given wire electrode, tubular cored electrode or 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 document. The classification in accordance with system A was mainly based on EN 12070:1999. The classification in accordance with system B is mainly based upon standards used around the Pacific Rim.

This document provides a classification system for solid wire electrodes in terms of their chemical composition, solid wire electrodes and tubular cored electrodes in terms of the chemical composition of the deposit 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 metal. 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. 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 wire electrodes and fluxes supplied by individual companies can have the same classification, the individual wire electrodes and fluxes from different companies are not interchangeable unless verified in accordance with this document.

It should be noted that the mechanical properties of all-weld metal test pieces used to classify the wire electrodes vary from those obtained in production joints because of differences in welding procedure, such as electrode size, welding position and material composition.

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