
Welding consumables — Deposition of a weld metal pad for chemical analysis

*Produits consommables pour le soudage — Exécution d'un dépôt de
métal fondu pour l'analyse chimique*

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Foreword

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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).

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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.

This document was prepared by IIW, *International Institute of Welding*, Commission II, *Arc Welding and Filler Metals*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This fourth edition cancels and replaces the third edition (ISO 6847:2013), which has been technically revised.

The main change compared to the previous edition is the addition of provisions for strip-flux combinations for use with cladding with the submerged arc welding and electroslag welding processes.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

The first edition of this document, ISO 6847:1985, addressed only the deposition of a weld metal pad for chemical analysis using covered electrodes for manual arc welding. This pad preparation was expensive to execute. IIW Commission II conducted testing of several methods of weld pad preparation that were less costly to execute than that of ISO 6847:1985 and yet produced equivalent results. Further, these methods were applicable to solid wires for gas shielded welding, to tubular cored wires for arc welding with or without gas shielding, and to wires and fluxes for submerged arc welding, as well as being applicable to covered electrodes. Accordingly, subsequent revisions (ISO 6847:2000 and ISO 6847:2013) simplified weld pad preparation and broadened the range of welding processes and filler metals. This document adds the use of strip with the submerged arc welding and electroslag welding processes.

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